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ENGINEERING DATA TRANSMITTAL

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ULTRASONIC INSPECTION RESULTS FOR DOUBLE-SHELL TANK 241-AP-101 - FY 2003

Chris E. Jensen

CH2M HILL HANFORD GROUP, INC.

Richland, WA 99352

U.S. Department of Energy Contract DE-AC27-99RL14047

EDT/ECN: EDT 633896

UC:

Cost Center: 7G220

Charge Code: 500445

B&R Code:

Total Pages: 226

Key Words: Ultrasonic, inspection, exaination, UT, TSAFT, synthetic apert

ure, DST

Abstract:

This report documents the required ultrasonic examination of double-shell tank 241-AP-101 performed during FY 2003. This examination included specified primary wall areas, welds, and lower knuckle. Results indicated that there was no reportable wall thinning, cracking, or pitting in any of the plate areas examined.

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ULTRASONIC INSPECTION RESULTS FOR DOUBLE-SHELL TANK 241-AP-101 – FY 2003

C.E. Jensen

CH2M HILL Hanford Group, Inc.

Date Published July 2003



Post Office Box 1500 Richland, Washington

Prepared for the U.S. Department of Energy Office of River Protection

Contract No. DE-AC27-99RL14047, Modification M030

Approved for public release; distribution is unlimited

Ultrasonic Inspection Results for Double-Shell Tank 241-AP-101 – FY 2003

July 2003

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TERMS

ASME American Society of Mechanical Engineers

CH2M HILL CH2M HILL Hanford Group, Inc.
COGEMA Engineering Corporation

DST double-shell tank

DSTIP Double-Shell Tank Integrity Project EPRI Electric Power Research Institute

FY fiscal year

HAZ heat-affected zone
JCS Job Control System

NDE Nondestructive Examination
PDT Performance Demonstration Test
PNNL Pacific Northwest National Laboratory

PUREX Plutonium Uranium Extraction Facility

RL U.S. Department of Energy, Richland Operations Office

RMS Root Mean Square

RONDE Remotely Operated Nondestructive Examination

SAFT Synthetic Aperture Focusing Technique

T-SAFT Tandem Synthetic Aperture Focusing Technique

TWINS Tank Waste Information Network System

TWRS Tank Waste Remediation System

UT Ultrasonic Testing

WDOE Washington State Department of Ecology

EXECUTIVE SUMMARY

Background

Through FY 1999, six double-shell tanks were ultrasonically examined to meet the integrity requirements of the *Washington Administrative Code*, Chapter 173-303, "Dangerous Waste Regulations". Subsequent to the examinations, integrity assessment reports were issued for each double-shell tank farm and submitted to the Washington State Department of Ecology in FY 1999. In June 2000, the Washington State Department of Ecology issued Administrative Orders 00NWPKW-1250 and 00NWPKW-1251 providing prescriptive examination requirements for all double-shell tanks by FY 2005. This report documents the required ultrasonic examination of double-shell tank 241-AP-101, completed in the third quarter of FY 2003.

Methodology

The primary wall examinations consisted of a vertical 30-inch strip consisting of two 15-inch ultrasonic examination scans. The primary wall vertical examinations were looking for wall thinning, cracking, and pitting in the tank wall. The weld heat affected zones examined included 20 linear feet of vertical welds and 20 linear feet of horizontal welds. A portion of the lower primary tank knuckle was also examined for thinning, pitting and cracking. These examinations were performed primarily using the P-scan nondestructive examination technique. A second technique, Tandem Synthetic Aperture Focusing Technique (T-SAFT), was used to examine the high stress region of the lower knuckle.

The ultrasonic examinations were carried out in accordance with ASME Boiler and Pressure Vessel Code, Section V, "Nondestructive Examinations". The personnel and non-destructive examination equipment were qualified to perform the examinations on the double-shell tanks by performance demonstration tests administered by Pacific Northwest National Laboratories.

The required accuracy for the ultrasonic examinations is to be within 0.020 inches for wall thinning, 0.050 inches for pitting, and 0.10 inches for cracking. The performance demonstration tests revealed that the examiners meet this requirement.

Results

Results indicated that there was no reportable wall thinning in any of the plate areas examined. This included both the primary wall vertical scans and the lower knuckle horizontal scan. In addition, there were no reportable pitting indications nor any crack-like indications detected in any of the plates. This included examination of the lower knuckle for cracks using the T-SAFT system.

There were also no crack-like indications detected in any of the weld heat-affected zones. This included the primary tank vertical weld scans and the knuckle-to-shell horizontal weld scan. In

addition, there were no reportable wall thinning nor reportable pitting indications detected in any of the weld heat-affected zones.

Conclusions

Based on the results of this examination, the material condition of the tank is satisfactory for continued operation.

The tanks inspected to date are summarized in the following table.

Double-Shell Tanks Inspected Through April 2003

Double-Shell		Inspection Year (FY)								
Tank	1997	1998	1999	2000	2001	2002	2003			
AN-101						х				
AN-102					х					
AN-105			х			(1)				
AN-106		, , , , , , , , , , , , , , , , , , , ,	х							
AN-107		x								
AP-101							X (3)			
AP-107				х						
AP-108				х		(2)				
AW-101					х					
AW-102						х	(4)			
AW-103	х			-	*					
AW-104						х				
AW-105					х	10				
AW-106						х				
AY-101					х	х				
AY-102			х							
AZ-101			х							

⁽¹⁾ Limited scope reexamination.

⁽²⁾ Linear indication evaluated.

⁽³⁾ Includes primary knuckle T-SAFT examination.

⁽⁴⁾ Primary knuckle T-SAFT examination only.

1.0 INTRODUCTION

In May 1996 the Tank Waste Remediation System (TWRS) Decision Board recommended, and U.S. Department of Energy, Richland Operations Office (RL) agreed, that the condition of the double-shell tanks (DST) should be determined by ultrasonic testing (UT) inspection of a limited area in six of the 28 DSTs (Figure 1-1). The Washington State Department of Ecology (WDOE) agreed with the strategy of limited ultrasonic inspection of DSTs. Data collected during the UT inspections will be used to assess the condition of the tank, judge the effects of past corrosion control practices, and satisfy a regulatory requirement to periodically assess the integrity of waste tanks.

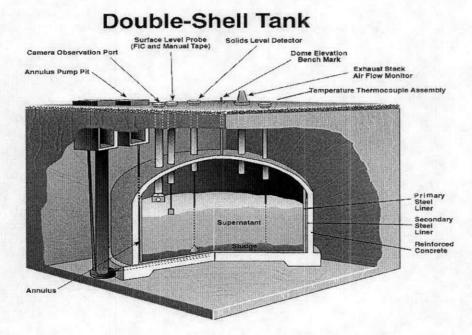


Figure 1-1. Typical Double-Shell Tank Configuration.

In November 1996, DST 241-AW-103 was the first tank inspected to determine if Hanford DST walls could be inspected without removing the existing surface rust and scale. Equipment similar to that used to perform routine inspections of oil tanks and large pipelines was used. UT sensors were mounted on a remote-controlled crawler that used magnetic wheels to affix itself and move about on the tank walls. The crawler was deployed into the tank annulus and vertically traversed the primary and secondary containment walls to collect data on the wall thickness and the size of any pits or cracks. The successful completion of this inspection met the requirements of RL Milestone T21-97-455 and represented the first UT inspection of a Hanford DST (*Final Report - Ultrasonic Examination of Tank 241-AW-103 Walls*, Leshikar 1997).

In fiscal year (FY) 1998, FY 1999, and FY 2000, similar inspections were performed per Engineering Task Plans HNF-2820 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks, Pfluger 1999) and RPP-5583 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2000, Jensen 2000) on 241-AN-107, 241-AN-106, 241-AN-105, 241-AY-102, 241-AZ-101, 241-AP-107, and 241-AP-108. An

attempt was made to examine 241-AY-101 in FY 1999, but corrosion product on the tank wall prevented reliable examination.

In June 2000, WDOE issued an Administrative Order requiring UT examinations of the remaining 20 DSTs through FY 2005 (Administrative Order No. 00NWPKW-1251, Failure to Comply with Major Milestone M-32 of the Tri-Party Agreement, Silver 2000). Based on the results of the above listed eight DST inspections and per WDOE Administrative Order requirements (Silver 2000), Engineering Task Plans RPP-6839 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2001, Jensen 2000a), RPP-7869 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2002, Jensen 2002), RPP-8867 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks 241-AP-108, 241-AY-101, and 241-AZ-102 - FY2002, Jensen 2002a), and RPP-11832 (Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks - FY2003, Jensen 2002b) were prepared for ultrasonic DST inspections scheduled for FY 2001, FY 2002, and FY 2003.

In FY 2001, UT inspections were performed on four DSTs: 241-AN-102, 241-AW-101, 241-AW-105, and 241-AY-101 (following cleaning of selected areas of the 241-AY-101 wall). In FY 2002, UT inspections were performed on five more DSTs: 241-AN-101, 241-AW-102, 241-AW-104, 241-AW-106 and 241-AY-101 (a more extensive examination of 241-AY-101). The FY 2002 examination of 241-AP-108 was limited to characterization of the linear indication found in FY 2000. In addition, a limited scope reexamination of the upper walls of tank 241-AN-105 was performed in FY 2002. A primary knuckle inspection on 241-AW-102 using the Tandem Synthetic Aperture Focusing Technique (T-SAFT) not completed during FY 2002 was completed in early FY 2003.

DST 241-AP-101 was the first of four tanks selected for inspection in FY 2003 (the others being 241-AP-103, 241-AP-105, and 241-AZ-102). Inspection of tank 241-AP-101 was completed in the third quarter of FY 2003, and is the subject of this report. The services of COGEMA Engineering Corporation (COGEMA Engineering) were retained to provide UT examinations, procedures and inspectors, and report the inspection results. Examination of 241-AP-101 was performed with UT equipment provided by CH2M HILL Hanford Group, Inc. (CH2M HILL).

2.0 OBJECTIVE AND SCOPE

This report describes the inspection system, evaluates the inspection results, and documents findings with conclusions and recommendations. The inspections were conducted in accordance with the criteria and scope set forth in RPP-11832 (Jensen 2002b) for the FY 2003 UT inspection of DST 241-AP-101.

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3.0 INSPECTION EQUIPMENT DESCRIPTION

Crawler / Scanning Bridge Systems – The crawler is a remotely controlled device that delivers the ultrasonic transducers to the tank walls. The crawler used during P-scan imaging weighs approximately 30 pounds and has dimensions (including its traveling bridge) of approximately 21 inches wide by 18 inches long by 6 inches high. The traveling bridge on the crawler can be outfitted with various ultrasonic transducer configurations (Figure 3-1).

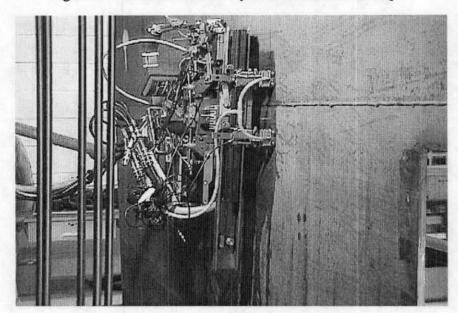
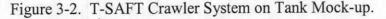


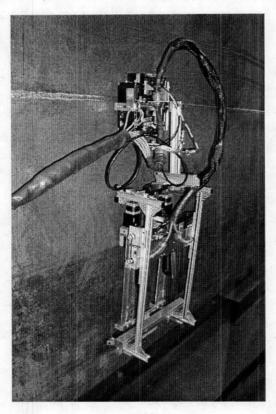
Figure 3-1. P-scan Crawler System on Tank Mock-up.

The same type of crawler was used on a remotely operated nondestructive examination (NDE) system which utilizes the Synthetic Aperture Focusing Technique / Tandem Synthetic Aperture Focusing Technique (SAFT/T-SAFT, hereafter referred to as the T-SAFT system) to examine the primary lower knuckle region for cracks. The crawler and its traveling bridge has dimensions of approximately 18.5 inches wide by 47 inches long by 9.5 inches high. The traveling bridge on the crawler is outfitted with two ultrasonic transducers (Figure 3-2).

Both the P-scan and the T-SAFT crawler systems are deployed through a 24 inch annulus inspection riser using customized deployment tools. The crawler attaches to the tank wall with two pairs of magnetic wheels. As the crawler moves slowly forward the transducers glide from side-to-side over the tank wall surface. Water couplant is continuously fed to each transducer at a rate needed to maintain an acceptable signal.

Deployment Tools – A deployment tool was specifically designed to insert and retrieve each scanning system into and out of the DST annular space. The scanner sits on a platform that is manually lowered to the appropriate elevation. The platform has cables attached that can be controlled to move the scanner platform into contact with the examination surface. The scanner is then driven onto the surface. The deployment tool is retracted until the scanner needs to be removed from the annular space.





P-scan – P-scan is the name of the computerized pulse-echo ultrasonic inspection system used by the inspection vendor. The P-scan system is manufactured by Force Institute in Denmark. It acquires data from zero and angle beam transducers mounted on the crawler, allows real-time analysis, and records the data in electronic memory for post inspection analysis. Force Institute has designated "P-scan mode" to represent the angle beam (flaw length) view and "T-scan mode" to represent the zero beam (thickness) view. T-scan mode is used for normal operation and, if crack-like indications are detected, then the P-scan mode is employed.

During normal T-scan and P-scan operations, the waveforms of the reflected sound wave signals for each transducer are displayed in the "A-scan monitoring mode". The displays are continuously monitored (but not saved), and are primarily used to verify that the transducers are functioning properly (e.g., there is proper probe contact, adequate water flowing, and correctly operating transducer cables). When an indication is detected, the area is rescanned using the "A-scan recording mode". The recorded A-scan waveforms are then reviewed off-line, serving as an additional tool in the evaluation of the indication.

T-SAFT – The Pacific Northwest National Laboratory (PNNL) developed a system capable of examining the entire knuckle region. This remotely operated NDE system utilizes an advanced signal processing method known as SAFT to introduce sound waves from above the knuckle region where access is readily achieved, and examine the knuckle region below. SAFT is recognized by national standards (ASME Boiler and Pressure Vessel Code, Section XI), and has been used for inservice inspection of commercial nuclear power plant components (*Real-Time 3-D SAFT-UT System Evaluation and Validation*, Doctor et al. 1996). The sound is divergent in

nature and propagates around the knuckle and along the bottom of the waste tank. The SAFT technique provides a detection and location method for cracks in the knuckle region.

PNNL used an advanced nondestructive evaluation method known as Tandem SAFT or T-SAFT, which utilizes two transducers in a pitch-catch mode, and has the ability to size the depth of the detected crack. The T-SAFT process is a technology development mandated by WDOE Administrative Order 00NWPKW-1251, Item 1b. The T-SAFT technique has undergone extensive trials internally at PNNL as well as the Network for Evaluating Structural Components¹ and the Program for the Inspection of Steel Components Phase III trials², and has successfully passed the Electric Power Research Institute (EPRI) Planar Flaw Sizing Demonstration on April 7, 1989 at the EPRI NDE center. Because of its ability to size defects using the strongly forward scattered signal without the requirement to detect the extremely weak tip diffracted signal, the T-SAFT technique was a very attractive solution to the inspection of the knuckle region of Hanford's double-shell waste tanks. The T-SAFT application used on the Hanford Site tanks was validated through a performance demonstration test (PDT) that met the intent of ASME Section XI Appendix VIII.

Overview Camera – This camera was deployed to observe the area immediately around the inspection area and to aid crawler deployment in the annulus.

Side-view Camera – This camera and light system were installed in a riser adjacent to the inspection riser to provide an overall view of the inspection process.

Riser Enclosure – A modular structure that is placed over the inspection riser. This structure is used to combat adverse weather conditions and supplies an internal hoist for deployment of equipment.

Data Acquisition Control Center – A pull-type trailer was used to house the crawler controls, video monitors, and data collection and evaluation hardware. The trailer was located inside the AP Tank Farm boundary fence.

¹ Network for Evaluating Structural Components, managed by the European Union Joint Research Centre "Institute for Energy" in Petten, the Netherlands.

Program for the Inspection of Steel Components Phase III, a major international program involving 15 countries and some 50 NDT teams from a hundred different institutions around the world, sponsored jointly with the Commission of the European Communities and the International Atomic Energy Agency.

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4.0 UT INSPECTION DESCRIPTION

The following is the description of the data collection methodology:

Tank inspection was performed under Job Control System (JCS) work package number 2E-02-1487. All work steps, guidelines, procedures, personnel responsibilities, and protocol for the inspection (Jensen 2002b) were included in the subject work package. Two COGEMA Engineering procedures establish the methods, equipment and requirements for the UT measurements and flaw detection. The P-scan imaging system procedure is *Automated Ultrasonic Examination For Corrosion And Cracking*, COGEMA-SVUT-INS-007.3 (Attachment 1), and the T-SAFT system procedure is *Ultrasonic Examination Of The Knuckle Region*, COGEMA-SVUT-INS-007.5 (Attachment 2).

Two remote crawler systems were utilized for the DST 241-AP-101 inspections:

<u>P-scan Crawler for Tank Walls and Knuckle</u> - The remotely controlled, steerable crawler was used to deliver the P-scan UT transducers to the tank wall (Figure 3-1). The crawler was deployed through the 24 inch diameter annulus inspection Riser Number 031 to perform the vertical wall scans, the knuckle wall scans and the vertical and horizontal weld scans.

The P-scan crawler inspects the primary tank wall using one dual-element 0° transducer to detect wall thinning and corrosion pitting, and two 45° shear-wave transducers to detect cracking transverse to the scanning direction. This examination setup is illustrated in the Figure 4-1 schematic.

Top View (Transducers Only) Side View Crawler Crawlet Scan Scan Travel Travel Direction Direction Direction O Direction Bridge Fixture Transducers Tank 0. Wallf 45° Angle-beam 0º Straight-beam Transducers Transducer Tank Wall Crack

Figure 4-1. Schematic of UT Setup for Vertical Wall Inspection

Vertical Wall Inspection Setup – Uses two 45° Transducers and one 0° Transducer (Inspect for Wall Thinning, Pitting and Axial Cracks)

To detect cracks parallel to the weld, a 60° shear-wave transducer was directed toward the weld and a dual-element 0° transducer is also included to detect wall thinning and corrosion pitting (Figure 4-2).

Side View Top View (Transducers Only) Crawler Crawler Scan Travel Scan Travel Direction Direction Direction Direction Bridge Fixture Transducers Fransducers Weld Tank 604 604 Wall 00 0. 0º Straight-beam 60° Angle-beam Transducer Transducer Tank Wall Cracks

Figure 4-2. Schematic of UT Setup for First Pass of Weld Inspections

First Pass of Vertical and Horizontal Weld Inspection – Uses two 60° Transducers and two 0° Transducers (Inspect for Wall Thinning, Pitting and HAZ Cracks Parallel to the Weld)

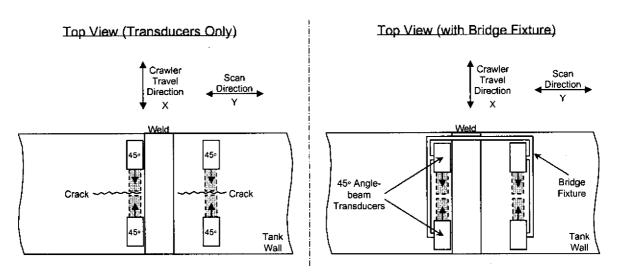
To detect cracks oriented perpendicular to welds, two opposing 45° shear-wave transducers were directed parallel to the weld. Welds were examined from both sides of the weld crown (Figure 4-3). Note that weld and weld examination refer to the UT examination of the heat-affected zone (HAZ).

A special extension arm was attached to the crawler to inspect the primary tank knuckle region. Two 45° shear-wave transducers were attached to the end of the arm to detect cracking transverse to the scanning direction (Figure 4-4). To detect wall thinning and corrosion pitting in the knuckle region, one dual-element 0° transducer was attached to the arm (Figure 4-5).

The setup in Figure 4-5 is used to examine extended, continuous lengths of the primary lower knuckle (typically 20 feet), but interference between the transducer and the insulating concrete pad below the knuckle restricts the examination region to the upper 11 to 12 inches of the knuckle. To inspect lower portions of the knuckle (within a few inches of the tank bottom plate weld), the P-scan transducer can be lined up with air slots in the insulating concrete, permitting approximately 1 inch wide scans in the selected slots (Figure 4-6).

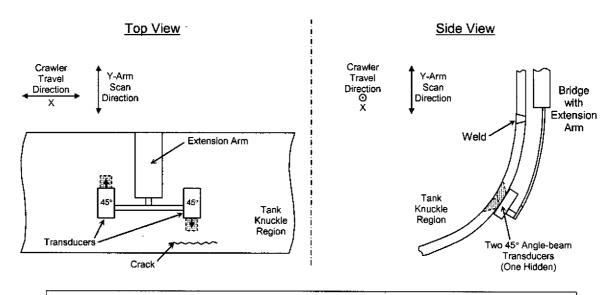
Data and images from the P-scan system were returned to a nearby control center located inside the tank farm fence. The control center contained the crawler controls, video monitors, and data collection and evaluation software and hardware. The UT inspector continuously monitored the signals for reportable indications. The entire inspection was viewed by a camera and lighting system deployed through an adjacent riser.

Figure 4-3. Schematic of UT Setup for Second Pass of Weld Inspections



Second Pass of Vertical and Horizontal Weld Inspection – Uses four 45° Transducers (Inspect for Heat-Affected Zone Cracks Perpendicular to the Weld)

Figure 4-4. Schematic of UT Setup for Inspection of Cracks at Knuckle



First Pass of Knuckle Inspection Setup – Uses two 45° Transducers (Inspect for Horizontal Knuckle Cracks)

Figure 4-5. Schematic of UT Setup for Inspection of Wall Thinning at Knuckle

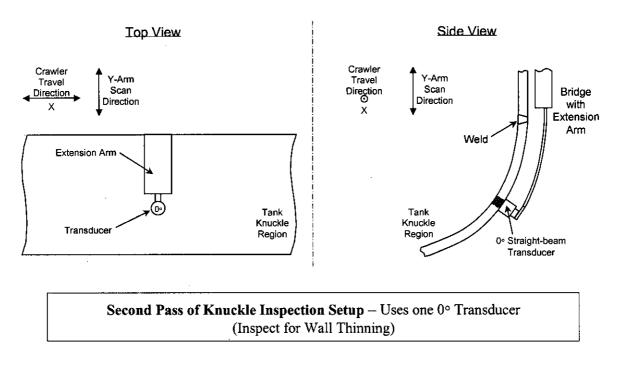
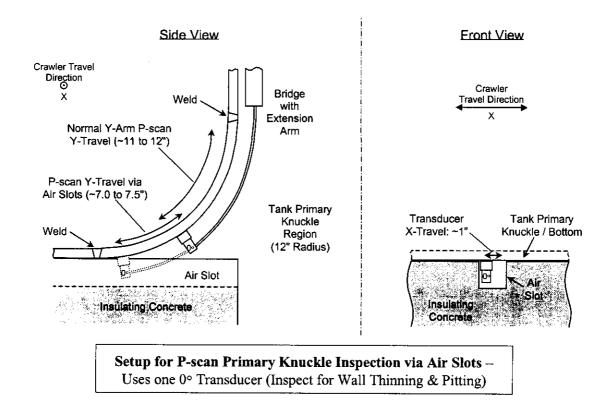


Figure 4-6. Schematic of UT Setup for Inspection of Wall Thinning at Knuckle via Air Slots



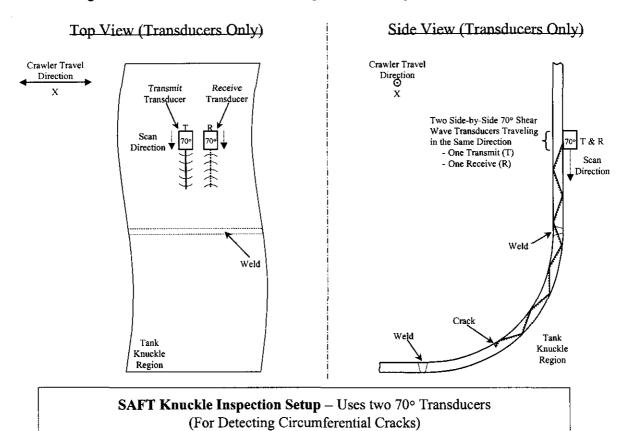
<u>T-SAFT Crawler for Lower Knuckle</u> - A remotely controlled, steerable crawler was also used to deliver the T-SAFT transducers to the tank wall (Figure 3-2). The crawler was deployed through the same 24 inch diameter annulus inspection Riser Number 031 to perform knuckle wall scans.

The T-SAFT crawler system inspects the primary tank lower knuckle wall using two 70° shear wave transducers in a "pitch-catch" mode. The T-SAFT system has the ability to detect and size (length and depth) circumferentially oriented cracks in the knuckle regions that are located beyond the reach of the P-scan crawler system. However, T-SAFT is not currently capable of identifying pitting or measuring wall thickness.

The two transducers are initially positioned side-by-side and are scanned in the same direction. This SAFT technique provides the method for detecting and locating cracks in the knuckle region. The examination setup is illustrated in Figure 4-7. If cracks are detected, then an advanced evaluation method, T-SAFT, utilizes the two transducers to size the detected crack. The transmit transducer initially starts in front of the receive transducer. Both transducers are scanned equal distances but in opposite directions. This examination setup is illustrated in Figure 4-8.

Some of the electronics to support the T-SAFT system were located near the inspection riser. These include the electronics for driving the scanning bridge mechanisms and electronics for the ultrasonic pulser/receiver for inspection of the tank knuckle. Data and images from the T-SAFT system were returned to the control center located inside the tank farm fence. The control center contained the electronics for driving the crawler, the video monitors, and data acquisition and analysis software and hardware. The inspector continuously monitored the signals for reportable indications. This inspection was also viewed by a camera and lighting system deployed through an adjacent riser.

Figure 4-7. Schematic of SAFT Setup for Detecting Cracks at Knuckle



Top View (Transducers Only) Side View (Transducers Only) Crawler Travel Direction Crawler Travel Direction O 1. Initial Position 2. Peak Position 3. Final Position Receive Transducer Scan Direction Two 70° Shear Wave Transducers Traveling in Opposite Directions Transmit (Shown Between Positions 2 & 3) Transducer - One Transmit (T) - One Receive (R) Scan A Direction Weld Crack Weld Tank Tank Knuckle Knuckle Region Region

Figure 4-8. Schematic of T-SAFT Setup for Sizing Cracks at Knuckle

T-SAFT Knuckle Inspection Setup – Uses two 70° Transducers (For Sizing Circumferential Cracks Detected by SAFT)

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5.0 INDICATION REPORTING CRITERIA

COGEMA Engineering was required to report to the customer the following anomalies:

- Wall thinning that exceeded 10 percent of the nominal wall thickness
- Pit depths that exceeded 25 percent of the nominal wall thickness
- Cracks that exceeded 0.1 inch in depth

The reporting criteria is established to identify indications that should be tracked. This tracking is to be used to determine if there is any active mechanism causing additional thinning, pit growth, or crack growth, based on subsequent examinations on the eight to ten year examination interval. The values are nominally 50% of the "acceptance criteria" established in *Acceptance Criteria for Non-Destructive Examination of Double-Shell Tanks* (Jensen 1995) and recommended in *Guidelines for Development of Structural Integrity Programs for DOE High-Level Waste Storage Tanks* (Bandyopadhyay et al. 1997).

For indications exceeding the "acceptance criteria", actions are initiated to evaluate the operability of the DST (Jensen 2002) through the occurrence reporting process. Indications exceeding the "reporting criteria" are reported to the CH2M HILL Project Engineer to be documented in the inspection report (Jensen 2002).

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6.0 PERFORMANCE DEMONSTRATION TESTS

Prior to field use, COGEMA Engineering personnel satisfactorily completed PDTs. The tests were conducted to qualify personnel, test procedures, and ensure the equipment's ability to detect and size wall thinning, pits, and cracks in a series of test plates with artificial defects. The performance demonstration tests were performed on a tank mock-up in the 306E Facility located in the Hanford Site 300 Area. This mock-up also demonstrated the successful deployment and retrieval of the equipment.

The PNNL report, "Report on Performance Demonstration Test – PDT, May 2000" (Attachment 3 of Ultrasonic Inspection Results of Double-Shell Tank 241-AP-108, Jensen 2000b) provides the details of the complete evaluation of the P-scan system PDT. The PNNL report, "SAFT/T-SAFT Performance Demonstration Test (PDT), November 14, 2002" (Attachment 3 of Ultrasonic Inspection Results of Double-Shell Tank 241-AW-102, Jensen 2003) provides the details on the qualification of COGEMA Engineering's Level III certified inspector on the T-SAFT system.

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7.0 TANK 241-AP-101 HISTORY

The 241-AP Tank Farm consists of eight DSTs located in the 200 East Area of the Hanford Site. These underground tanks were built from 1983 through 1986, and are 75 feet in diameter with an operating capacity of 1.16 million gallons.

Tank 241-AP-101 entered service in 1986. It began receiving non-complexed waste and continued to receive this waste until May 1990. From June 1990 until March 1994, the tank waste was designated as dilute non-complexed waste (Supporting Document for the Southeast Quadrant Historical Tank Content Estimate for AP-Tank Farm, Brevick et al., 1995). It is currently classified as a double-shell slurry feed (DSSF) tank, designed for storage of double-shell slurry waste produced at the 242-A Evaporator. The tank contains approximately 1,112,000 gallons of supernatant, equivalent to approximately 404 inches of supernatant (Waste Tank Summary Report for Month Ending February 28, 2003, Hanlon 2003).

The waste level history since September 1986 is shown in Figure 7-1, based on data obtained from the Tank Waste Information Network System (TWINS)³.

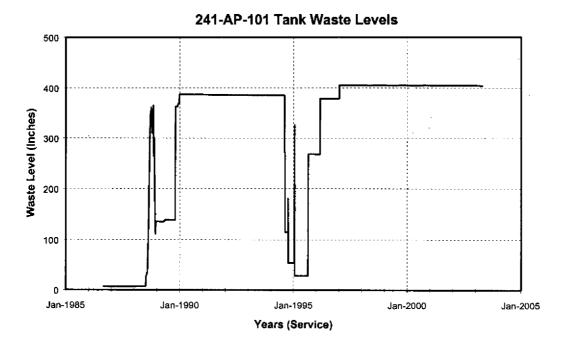


Figure 7-1. Waste Level History of Double-Shell Tank 241-AP-101.

Since July 1988, when the first waste transfer into the tank was made, the minimum recorded waste level was approximately 28 inches (January 26 to August 25, 1995). The maximum

TWINS, http://twins.pnl.gov:8001/twins.htm, queried 04/22/2003 [Data Source: Measurements, SACS, Surface Level, Tank Name AP-101, All Measurement Date values]

recorded waste level was approximately 406 inches, occurring since January 10, 1997, during which the level has remained relatively constant between 404.1 and 406.0 inches, averaging 405.1 inches.

Recorded temperatures of the tank have ranged from a maximum of 74°F (September and October 1995) and 74.6°F (January 2003) to a minimum of 53°F (March and April 1993, and April 1995), based on data obtained from the TWINS⁴.

⁴ TWINS, http://twins.pnl.gov:8001/twins.htm, queried 04/21/2003 [Data Source: Measurements, SACS, Tank Temperature Readings, Tank Name AP-101, All Measurement Date values]

8.0 GENERAL REQUIREMENTS AND INSPECTION SCOPE

FY 2003 Contract Number 16449 specifies that the contractor provide (among others) the following deliverables to the Double-Shell Tank Integrity Project (DSTIP) organization:

- The contractor shall provide AP-101 NDE Support and Data Analysis
- The contractor shall prepare recommended engineering reports and studies as directed by the DSTIP project leads

The areas on the primary tank that were identified for UT inspection in the engineering task plan (Jensen 2002b) are described below.

Primary Tank Wall and Welds:

- A vertical strip (approximately 30 inches wide by 35 feet long) of the primary wall between the upper haunch transition and the lower knuckle. The vertical strip may be comprised of one or more strips whose total width is 30 inches.
- Twenty feet of the circumferential weld joining the cylinder to the lower knuckle. One vertical weld joining the lowest shell course plates (about 10 feet of weld), and one vertical weld joining the next to the lowest shell course plates (about 10 feet of weld). A minimum of twenty (20) feet of vertical weld shall be examined.

Primary Tank Knuckle:

• A strip in the primary lower knuckle to detect the presence of cracks orientated in the circumferential direction, and for pits and wall thinning. The area to be examined is 20 feet long in the circumferential direction and, in the meridional direction, is from the weld joining the transition plate with the knuckle to the furthest reach of the transducer assembly that is allowed by the tank geometric constraints (using the flexible arm attachment to the existing P-scan system, supplemented by T-SAFT, if available). The 20-foot dimension is not required to be a continuous length.

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9.0 EQUIPMENT SETUP AT AP TANK FARM

Prior to performing the actual inspection, the riser (number 031, 24 inch) shield plug was removed, and a temporary cover and riser extension were secured to the riser. A portable enclosure was installed over the riser to provide the means for deploying the UT equipment and protecting the operators from the weather. An electric chain hoist, mounted to the roof frame, was used for maneuvering the equipment into position. The control center trailer was set up inside the AP Tank Farm's boundary fence, and the control cables were run along the ground to the equipment located at the riser. The tank farm setup for DST 241-AP-101 is shown in Figure 9-1. Some of the electronics to support the T-SAFT system were also located near the inspection riser.

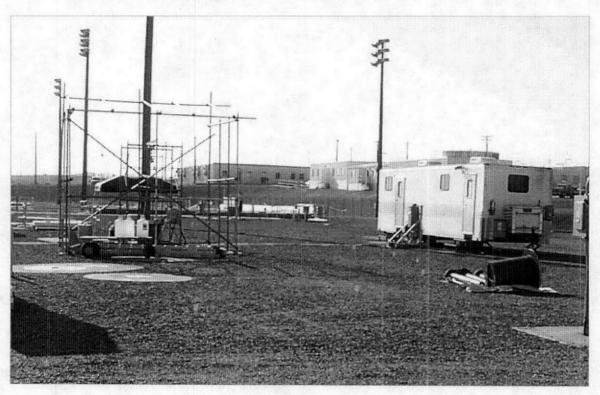


Figure 9-1. Field Set-Up at Riser 031 for Double-Shell Tank 241-AP-101

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10.0 INSPECTION RESULTS

Tank 241-AP-101 was fabricated from carbon steel plate. The primary tank's exterior surface varies from mill scale to coatings of various degrees of rust caused by in-service corrosion of carbon steel. A description of the plates is as follows with the location of the plates as shown in Figure 10-1 (*Tank Cross Section 241-AP Tanks*, Braun-Hanford 1986).

Primary knuckle (top) - Connects dome of tank to side-wall

Primary wall – Consists of (from top to bottom)

Plate #1 – approximately 7 feet 8 inch tall, 1/2 inch nominal thickness

Plate #2 – approximately 7 feet 8 inch tall, 1/2 inch nominal thickness

Plate #3 – approximately 7 feet 8 inch tall, 9/16 inch nominal thickness

Plate #4 – approximately 9 feet tall, 3/4 inch nominal thickness

Plate #5 – approximately 2 feet tall, 7/8 inch nominal thickness

Primary knuckle (bottom) – Approximately 15/16 inch nominal thickness. Connects sidewall of tank to primary tank bottom.

The P-scan crawler was deployed through the 24 inch diameter annulus inspection Riser 031 on the west side of tank 241-AP-101 for examinations of the primary wall, the lower knuckle, and vertical and horizontal welds. All tank welds examined were in the "as-welded" condition. The T-SAFT crawler was also deployed through the 24 inch diameter annulus inspection Riser 031 for examination of the lower knuckle. The various scan paths for the crawlers are shown in Figure 10-1, along with other pertinent tank information. Additional P-scan measurements of the lower knuckle were made using the P-scan crawler equipped with the extension arm lined up with air slots in the insulating concrete. The locations of these scan paths are shown in the Figure 10-2 schematic.

The UT P-scan data and the T-SAFT data were examined by COGEMA Engineering's Level III certified inspector. The P-scan data were also examined by Limited Level II certified inspectors. The Limited Level II inspectors were "P-scan Limited", indicating that they are qualified to collect and examine the P-scan data, but are not qualified to interpret the data.

The following pages contain tables that present summary and detailed wall thickness data, which were derived from the COGEMA "Automated Ultrasonic Thickness Data Report Sheets". The inspection data sheets, the transducer calibration sheets, the original tank wall and weld scan map, and an interpretation of the data by an independent Level III certified NDE Inspector are included in Attachment 3 for the P-scan data.

Also included in the following pages are tables that present summary and detailed scan data derived from the "SAFT/T-SAFT Ultrasonic Data Report Sheets". The inspection data sheet, the transducer calibration sheet and the original tank knuckle scan map are included in Attachment 4 for T-SAFT data.

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Figure 10-1. Schematic of UT Scan Paths on West Side of Tank 241-AP-101 Wall (via Riser 031)

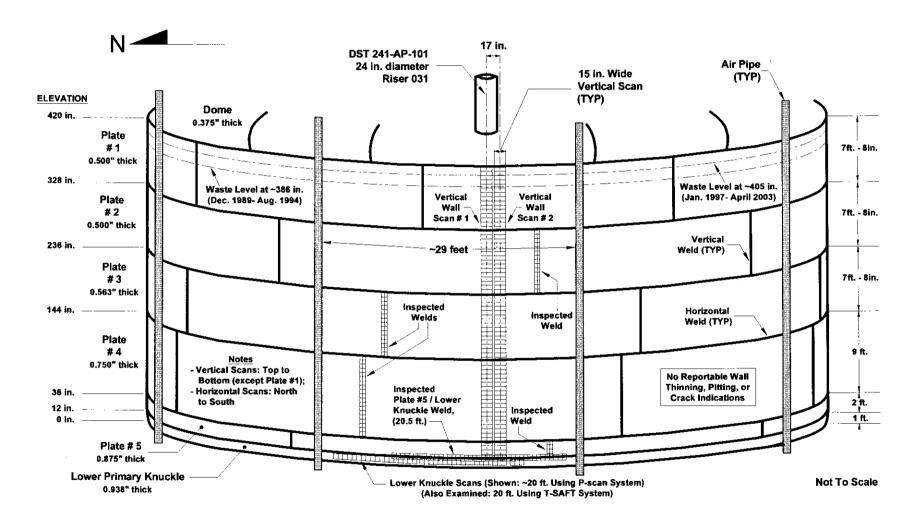
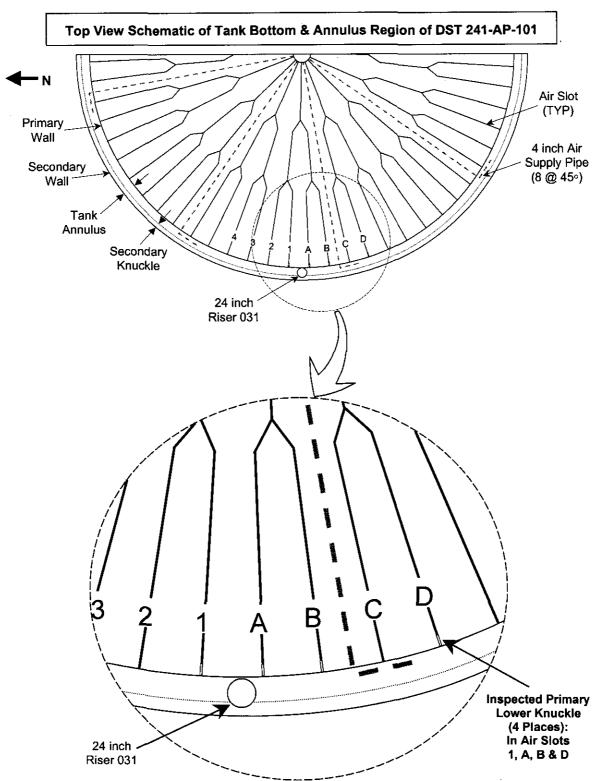


Figure 10-2. Schematic of UT Scan Paths on Primary Lower Knuckle in Air Slots for Tank 241-AP-101



Ref: H-2-90440 H-2-90534 Tables 10-1 through 10-5 show the measured minimum wall thickness values obtained using the P-scan system, and are displayed in a summarized form by wall plates (including the lower knuckle), vertical plate welds, and horizontal knuckle weld. Although the data are reported to three significant figures, the accuracy of the wall thickness data, based on the results of the performance demonstration test, is 0.012 inch root-mean-square (RMS).

Table 10-6 summarizes the results of the probe of the knuckle region for cracks using the T-SAFT system.

Table 10-1. Summary of Primary Tank Wall Scan 1 (via Riser 031)

Plate Description	Elevation of Wall Scan (inches)	Wall Scan Distance (inches) (1)	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Plate #1	329 to 416.9 (2)	87.9	0.500	0.501	100.2%
Plate #2	327 to 237.3	89.7	0.500	0.501	100.2%
Plate #3	235 to 145.3	89.7	0.563	0.539	95.7%
Plate #4	143 to 37.1	105.9	0.750	0.742	98.9%
Plate #5	35 to 14.1	20.9	0.875	0.860	98.3%

⁽¹⁾ All scan widths were 15 inches.

⁽²⁾ Scan was started at the <u>bottom</u> of Plate #1 and conducted <u>upward</u> due to paper taped on the dome; all remaining "Scan 1" vertical scans conducted from top to bottom.

Table 10-2. Summary of Primary Tank Wall Scan 2 (via Riser 031)

Plate Description	Elevation of Wall Scan (inches)	Wall Scan Distance (inches) (1)	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Plate #1	329 to 415.3 ⁽²⁾	86.3	0.500	0.492	98.4%
Plate #2	327 to 237.45	89.55	0.500	0.498	99.6%
Plate #3	235 to 146.4	88.6	0.563	0.558	99.1%
Plate #4	143 to 38.4	104.6	0.750	0.741	98.8%
Plate #5	35 to 13.8	21.2	0.875	0.866	99.0%

⁽¹⁾ All scan widths were 15 inches.

Table 10-3. Summary of Primary Tank Lower Knuckle Scan Using the P-scan System (via Riser 031)

Plate Description	Vertical Location of Knuckle Scan	Knuckle Scan Distance (inches)	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Upper Portion of Lower Knuckle	From 2 inches to 13.5 – 14.4 inches below Plate #5 / Knuckle Weld	Horizontal Distance: 235.3 (1)	0.938	0.866	92.3%
Lower Portion of Lower Knuckle (in 4 Air Slots)	From approx. 10 – 12 inches to approx. 16 – 18 inches below Plate #5 / Knuckle Weld	Total Vertical Distance in 4 Air Slots: 27.6 (2)	0.938	0.944	100.6%

⁽¹⁾ Scan widths were 11.5 – 12.4 inches.

⁽²⁾ Scan was started at the <u>bottom</u> of Plate #1 and conducted <u>upward</u> due to paper taped on the dome; all remaining "Scan 2" vertical scans conducted from top to bottom.

 $^{^{(2)}}$ Horizontal x-travels of scans in slots were 0.87-1.0 inches.

Table 10-4. Summary of Primary Tank Vertical Weld Scans (via Riser 031)

Weld Description	Elevation of Weld Scan	Weld Scan Distance	Design Nominal	Measured Minimum	Scan Minimum %
	(inches)	(inches) ⁽¹⁾	(inches)	(inches)	of Nominal
Vertical Weld Plate #2	327 to 236.7	90.3	0.500	0.499	99.8%
Vertical Weld Plate #3	235 to 146.1	88.9	0.563	0.562	99.8%
Vertical Weld Plate #4	143 to 36.7	106.3	0.750	0.719	95.9%
Vertical Weld Plate #5	35 to 19.9	15.1	0.875	0.852	97.4%

⁽¹⁾ Scan widths were 9.8 - 11.1 inches.

Table 10-5. Summary of Plate #5 / Knuckle Horizontal Weld Scans (via Riser 031)

Weld Description	Vertical Location of Weld Scan	Weld Scan Distance (inches) (1)	Design Nominal (inches)	Measured Minimum (inches)	Scan Minimum % of Nominal
Horizontal Weld Plate #5 to Knuckle, Plate-side	From ~1 in. to ~5.1 in. above Plate #5 / Knuckle Weld	245.6	0.875	0.854	97.6%
Horizontal Weld Plate #5 to Knuckle, Knuckle-side	From ~1 in. to ~5.1 in. below Plate #5 / Knuckle Weld	245.6	0.938	0.884	94.2%

⁽¹⁾ Scan widths were 10.3 inches.

Table 10-6. Summary of Primary Tank Lower Knuckle Scan Using the T-SAFT System (via Riser 031)

Plate Description	T-SAFT File Numbers	Vertical Location of Horizontal Knuckle Scan	Knuckle Horizontal Scan Distance (inches) ⁽¹⁾	Comments
Lower Knuckle	Files 1 – 24	SAFT / T-SAFT transducers located above the Plate #5 / Knuckle Weld, but entire Lower Knuckle (from weld to weld) probed for cracks	~240	No cracks detected using the SAFT mode

⁽¹⁾ Each T-SAFT file represents a horizontal scan of 12.5 inches, but the crawler is moved only 10 inches after each scan to ensure overlap. Therefore, the total knuckle scan distance for the 25 files would be a few inches above 240 inches.

Tables 10-7 through 10-16 contain the detailed data for wall scans as presented in 12 inch long by 15 inch wide connecting scans. Table 10-17 contains the detailed P-scan data for the lower knuckle scans as presented in 12 inch long by 11.5 to 12.4 inch wide connecting scans. Table 10-18 contains the detailed P-scan data for lower knuckle scans in individual air slots as presented in 5.7 to 7.5 inch long by 0.87 to 1.0 inch wide scans. Table 10-19 contains information on the T-SAFT data scans. The detailed data for vertical and horizontal welds are presented in 12 inch long by 9.8 to 11.1 inch wide scans in Tables 10-20 through 10-25.

Table 10-7. Primary Tank Vertical Wall Scan 1 - Plate 1 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches) (1)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	413	84 – 87.9 ⁽²⁾	0.500	0.520	0.509
	401	72 – 84	0.500	0.520	0.511
	389	60 – 72	0.500	0.520	0.510
Scan "Vert. Wall / Plate 1"	377	48 – 60	0.500	0.518	0.509
(Page Att. 3-3)	365	36 – 48	0.500	0.516	0.507
(Tage Au. 3-3)	353	24 – 36	0.500	0.515	0.509
	341	12 – 24	0.500	0.512	0.507
	329	0 – 12	0.500	0.510	0.501

⁽¹⁾ Scan was started at the bottom of Plate 1 and conducted upward due to paper taped on the dome.

⁽²⁾ Scan start was 1 inch above the centerline of the second horizontal weld, and centerline of 24 inch Riser 031; Scan width was 15 inches.

Table 10-8. Primary Tank Vertical Wall Scan 1 - Plate 2 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	327	0 – 12 (1)	0.500	0.516	0.508
	315	12 – 24	0.500	0.520	0.512
	303	24 – 36	0.500	0.524	0.515
Scan "Vert. Wall / Plate 2"	291	36 – 48	0.500	0.524	0.515
(Page Att. 3-5)	279	48 – 60	0.500	0.525	0.504
(1 ago 1100 5 5)	267	60 – 72	0.500	0.524	0.514
	255	72 – 84	0.500	0.520	0.510
	243	84 – 89.7	0.500	0.517	0.501

⁽¹⁾ Scan start was 1 inch below the centerline of the second horizontal weld, and centerline of 24 inch Riser 031; Scan width was 15 inches.

Table 10-9. Primary Tank Vertical Wall Scan 1 - Plate 3 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	235	0 – 12 (1)	0.563	0.585	0.563
	223	12 – 24	0.563	0.585	0.567
G 497 4 377 11 /	211	24 – 36	0.563	0.585	0.570
Scan "Vert. Wall / Plate 3"	199	36 – 48	0.563	0.585	0.573
(Page Att. 3-7)	187	48 – 60	0.563	0.585	0.558
	175	60 – 72	0.563	0.585	0.571
	163	72 – 84	0.563	0.585	0.539
	151	84 – 89.7	0.563	0.580	0.563

⁽¹⁾ Scan start was 1 inch below the centerline of the third horizontal weld, and centerline of 24 inch Riser 031; Scan width was 15 inches.

Table 10-10. Primary Tank Vertical Wall Scan 1 - Plate 4 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	143	0 – 12 (1)	0.750	0.759	0.742
	131	12 – 24	0.750	0.762	0.756
	119	24 – 36	0.750	0.762	0.756
Scan "Vert. Wall /	107	36 – 48	0.750	0.762	0.758
/ 0 / 1 st / Plate 4"	95	48 – 60	0.750	0.761	0.757
(Page Att. 3-9)	83	60 – 72	0.750	0.761	0.756
	71	72 – 84	0.750	0.760	0.755
	59	84 – 96	0.750	0.759	0.746
	47	96 – 105.9	0.750	0.755	0.746

⁽¹⁾ Scan start was 1 inch below the centerline of the fourth horizontal weld, and centerline of 24 inch Riser 031; Scan width was 15 inches.

Table 10-11. Primary Tank Vertical Wall Scan 1 - Plate 5 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Vert. Wall / Plate 5"	35	0 – 12 ⁽¹⁾	0.875	0.875	0.865
(Page Att. 3-11)	23	12 – 20.9	0.875	0.875	0.860

⁽¹⁾ Scan start was 1 inch below the centerline of the fifth horizontal weld, and centerline of 24 inch Riser 031; Scan width was 15 inches.

Table 10-12. Primary Tank Vertical Wall Scan 2 - Plate 1 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches) (1)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	413	84 – 86.3 (2)	0.500	0.515	0.502
	401	72 – 84	0.500	0.520	0.511
	389	60 – 72	0.500	0.520	0.509
Scan "Vert. Wall / 2 nd / Plate 1"	377	48 – 60	0.500	0.520	0.511
(Page Att. 3-13)	365	36 – 48	0.500	0.520	0.515
(Tage Att. 3-13)	353	24 – 36	0.500	0.520	0.512
	341	12 – 24	0.500	0.515	0.511
	329	0 – 12	0.500	0.515	0.492

⁽¹⁾ Scan was started at the bottom of Plate 1 and conducted upward due to paper taped on the dome.

Table 10-13. Primary Tank Vertical Wall Scan 2 - Plate 2 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Vert. Wall / 2 nd / Plate 2"	327	0 – 12 (1)	0.500	0.520	0.501
(Page Att. 3-15)	315	12 – 21.4	0.500	0.520	0.517
	305.75	0 – 12 (2)	0.500	0.520	0.511
G (31 , 33 1) /	293.75	12 – 24	0.500	0.520	0.505
Scan "Vert. Wall / 2 nd / Plate 2A"	281.75	24 – 36	0.500	0.520	0.500
(Page Att. 3-17)	269.75	36 – 48	0.500	0.520	0.517
	257.75	48 – 60	0.500	0.520	0.516
	245.75	60 – 68.3	0.500	0.520	0.498

⁽¹⁾ Scan start was 1 inch below the centerline of the second horizontal weld, and 17 inches south of Scan 1, centerline to centerline; Scan width was 15 inches.

⁽²⁾ Scan start was 1 inch above the centerline of the second horizontal weld, and 17 inches south of Scan 1, centerline to centerline; Scan width was 15 inches.

⁽²⁾ Start of scan @ 21.25 inches of previous scan; Scan width was 15 inches.

Table 10-14. Primary Tank Vertical Wall Scan 2 - Plate 3 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	235	0 – 12 (1)	0.563	0.585	0.564
	223	12 – 24	0.563	0.585	0.558
	211	24 – 36	0.563	0.585	0.571
Scan "Vert. Wall / 1 2 nd / Plate 3"	199	36 – 48	0.563	0.590	0.574
(Page Att. 3-19)	187	48 – 60	0.563	0.590	0.574
(1450 1100 2 12)	175	60 – 72	0.563	0.590	0.574
	163	72 – 84	0.563	0.590	0.569
	151	84 – 88.6	0.563	0.585	0.559

⁽¹⁾ Scan start was 1 inch below the centerline of the third horizontal weld, and 17 inches south of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-15. Primary Tank Vertical Wall Scan 2 - Plate 4 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	143	0 – 12 (1)	0.750	0.760	0.745
	131	12 – 24	0.750	0.760	0.754
	119	24 – 36	0.750	0.765	0.755
Scan "Vert. Wall /	107	36 – 48	0.750	0.765	0.751
2 nd / Plate 4"	95	48 – 60	0.750	0.765	0.759
(Page Att. 3-21)	83	60 – 72	0.750	0.765	0.757
	71	72 – 84	0.750	0.765	0.750
	59	84 – 96	0.750	0.762	0.741
	47	96 – 104.6	0.750	0.760	0.748

⁽¹⁾ Scan start was 1 inch below the centerline of the fourth horizontal weld, and 17 inches south of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-16. Primary Tank Vertical Wall Scan 2 - Plate 5 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Wall Scan (inches)	Vertical Location of Wall Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Vert. Wall / 2 nd / Plate 5"	35	0 – 12 ⁽¹⁾	0.875	0.876	0.871
(Page Att. 3-23)	23	12 – 21.2	0.875	0.875	0.866

⁽¹⁾ Scan start was 1 inch below the centerline of the fifth horizontal weld, and 17 inches south of Scan 1, centerline to centerline; Scan width was 15 inches.

Table 10-17. Primary Tank Lower Knuckle Scan Using the P-scan System (via Riser 031)

Scan I.D. Number (Data Sheets)	Vertical Location of Horizontal Knuckle Scan	Horizontal Location of Knuckle Scan (inches)	Design Nominal (inches)	Measured Average . (inches)	Measured Minimum (inches)
		0 – 12 (1)	0.938	0.937	0.889
		12 – 24	0.938	0.935	0.909
		24 – 36	0.938	0.935	0.912
Scan	From 2 in. to	36 – 48	0.938	0.935	0.906
"Y-Arm / Knuckle"	14.4 in. below Plate #5 /	48 60	0.938	0.934	0.891
(Page Att. 3-25)	Knuckle Weld	60 – 72	0.938	0.935	0.871
		72 – 84	0.938	0.935	0.875
		84 – 96	0.938	0.939	0.891
		96 – 104.7	0.938	0.938	0.905
		0 – 12 (2)	0.938	0.945	0.895
		12 – 24	0.938	0.945	0.897
		24 – 36	0.938	0.940	0.908
Scan	From 2 in, to	36 – 48	0.938	0.936	0.897
"Y-Arm /	13.5 in. below	48 – 60	0.938	0.932	0.898
Knuckle A"	Plate #5 /	60 – 72	0.938	0.935	0.890
(Page Att. 3-27)	Knuckle Weld	72 – 84	0.938	0.932	0.866
		84 – 96	0.938	0.930	0.880
		96 – 108	0.938	0.930	0.871
		108 – 114.5	· 0.938	0.930	0.877
Scan "Y-Arm /	From 2 in. to 14.2 in. below Plate #5 / Knuckle Weld	0 – 12 (3)	0.938	0.950	0.906
Knuckle B" (Page Att. 3-29)		12 – 16.1	0.938	0.955	0.916

⁽¹⁾ Start of scan @ next to the air tube north of 24 inch riser; Scan width was 12.4 inches.

⁽²⁾ Start of scan @ south side of vertical weld, north of 24 inch riser; Scan width was 11.5 inches.

⁽³⁾ Start of scan @ south side of second vertical weld, south of 24 inch riser; Scan width was 12.2 inches.

Table 10-18. Primary Tank Lower Knuckle Scan Using the P-scan System in Air Slots (via Riser 031)

Scan I.D. Number (Data Sheets)	Vertical Location of Knuckle Scan in Slot	Vertical Y-Travel of Knuckle Scan in Slot (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Y-Arm / Slot 1" (Page Att. 3-31)	Exact starting positions not determined, but	7.5 ⁽¹⁾	0.938	0.950	0.945
Scan "Y-Arm / Slot A" (Page Att. 3-32)	approximately 10 to 12 inches below the Plate #5 /	5.7 ⁽²⁾	0.938	0.960	0.954
Scan "Y-Arm / Slot B" (Page Att. 3-33)	Knuckle Weld; Scans overlap areas examined	7.3 ⁽³⁾	0.938	0.957	0.944
Scan "Y-Arm / Slot D" (Page Att. 3-34)	in continuous scans (see Table 10-17)	7.1 ⁽⁴⁾	0.938	0.968	0.955

⁽¹⁾ Horizontal x-travel of scan in slot was 0.87 inches.

Table 10-19. Primary Tank Lower Knuckle Scan Using the T-SAFT System (via Riser 031)

T-SAFT File Number (Data Sheets)	Vertical Location of Horizontal Knuckle Scan	Horizontal Distance of T-SAFT Knuckle Scan (inches) (1)	Comments
Files 1 through 24 (Page Att. 4-3)	SAFT / T-SAFT transducers located above the Plate #5 / Knuckle Weld, but entire Lower Knuckle (from weld to weld) probed for cracks	0 to ~240 ⁽²⁾	No cracks detected using the SAFT mode

⁽¹⁾ Each T-SAFT file represents a horizontal scan of 12.5 inches, but the crawler is moved only 10 inches after each scan to ensure overlap.

⁽²⁾ Horizontal x-travel of scan in slot was 1.0 inches.

⁽³⁾ Horizontal x-travel of scan in slot was 0.9 inches.

⁽⁴⁾ Horizontal x-travel of scan in slot was 1.0 inches.

⁽²⁾ Start of scan @ vertical weld on knuckle north of 24 inch riser.

Table 10-20. Primary Tank Vertical Wall Weld Scan - Plate 2 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	327	0 – 12 (1)	0.500	0.512	0.499
	315	12 – 24	0.500	0.515	0.506
Scan	303	24 – 36	0.500	0.515	0.509
"Vert. Weld / 0 /	291	36 – 48	0.500	0.515	0.510
60 / Plate 2"	279	48 – 60	0.500	0.518	0.504
(Page Att. 3-35)	267	60 – 72	0.500	0.517	0.500
	255	72 – 84	0.500	0.515	0.506
	243	84 – 90.3	0.500	0.515	0.501

⁽¹⁾ Scan start was 1 inch below the centerline of the second horizontal weld; Scan width was 9.8 inches.

Table 10-21. Primary Tank Vertical Wall Weld Scan - Plate 3 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	235	0 – 12 (1)	0.563	0.580	0.562
	223	12 – 24	0.563	0.583	0.562
Scan	211	24 – 36	0.563	0.584	0.568
"Vert. Weld/	199	36 – 48	0.563	0.585	0.570
Plate 3"	187	48 – 60	0.563	0.585	0.565
(Page Att. 3-37)	175	60 – 72	0.563	0.590	0.570
	163	72 – 84	0.563	0.585	0.563
	151	84 – 88.9	0.563	0.580	0.564

⁽¹⁾ Scan start was 1 inch below the centerline of the third horizontal weld; Scan width was 11.1 inches.

Table 10-22. Primary Tank Vertical Wall Weld Scan - Plate 4 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan	143	0 – 12 (1)	0.750	0.755	0.719
"Vert. Weld / Plate 4"	131	12 – 24	0.750	0.755	0.725
(Page Att. 3-39)	119	24 – 28	0.750	0.755	0.740
	115.1	0 – 12 (2)	0.750	0.755	0.741
	103.1	12 – 24	0.750	0.755	0.736
Scan	91.1	24 – 36	0.750	0.755	0.741
"Vert. Weld / Plate 4A"	79.1	36 – 48	0.750	0.755	0.730
(Page Att. 3-39)	67.1	48 – 60	0.750	0.755	0.739
	55.1	60 – 72	0.750	0.750	0.727
	43.1	72 – 78.4	0.750	0.745	0.736

⁽¹⁾ Scan start was 1 inch below the centerline of the fourth horizontal weld; Scan width was 11.0 inches.

Table 10-23. Primary Tank Vertical Wall Weld Scan - Plate 5 (via Riser 031)

Scan I.D. Number (Data Sheets)	Elevation of Start of Weld Scan (inches)	Vertical Location of Weld Scan (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
Scan "Vert. Weld /	35	0 – 12 (1)	0.875	0.875	0.855
Plate 5" (Page Att. 3-41)	23	12 – 15.1	0.875	0.872	0.852

⁽¹⁾ Scan start was 1 inch below the centerline of the fifth horizontal weld; Scan width was 10.9 inches.

⁽²⁾ Start of scan @ 27.9 inches of previous scan; Scan width was 11.0 inches.

Table 10-24. Primary Tank Horizontal Weld - Plate 5 to Knuckle Scan, Plate Side (via Riser 031)

Scan I.D. Number (Data Sheets)	Vertical Location of Horizontal Weld Scan	Horizontal Location of Weld Scan, Plate Side (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
		0 – 12 (1)	0.875	0.875	0.860
Scan	From ~1 in. to	12 – 24	0.875	0.876	0.872
"Horz. Weld	~5.1 in. above	24 – 36	0.875	0.876	0.868
Plate / Knuckle"	Plate #5 / Knuckle Weld	36 – 48	0.875	0.876	0.867
(Page Att. 3-47)	Kiluckie weld	48 – 60	0.875	0.877	0.869
		60 – 65.4	0.875	0.877	0.867
		$0-12^{(2)}$	0.875	0.875	0.865
·		12 – 24	0.875	0.878	0.869
		24 – 36	0.875	0.878	0.858
Scan		36 – 48	0.875	0.878	0.874
"Horz. Weld Plate /	From ~1 in. to ~5.1 in. above	48 – 60	0.875	0.877	0.870
Knuckle A"	Plate #5 / Knuckle Weld	60 – 72	0.875	0.876	0.866
(Page Att. 3-48)	Kliuckie Weiu	72 – 84	0.875	0.875	0.866
		84 – 96	0.875	0.876	0.866
		96 – 108	0.875	0.876	0.871
		108 – 120	0.875	0.876	0.861
		0 – 12 (3)	0.875	0.878	0.875
Scan	From ~1 in. to	12 – 24	0.875	0.878	0.873
"Horz. Weld Plate /	~5.1 in. above	24 – 36	0.875	0.880	0.867
Knuckle B"	Plate #5 / Knuckle Weld	36 – 48	0.875	0.881	0.875
(Page Att. 3-50)	Miluckie weld	48 – 60	0.875	0.880	0.854
		60 – 61.9	0.875	0.882	0.875

⁽¹⁾ Start of scan @ 3rd air slot south of north air line; Scan width was 10.3 inches.

⁽²⁾ Start of scan @ 63.7 inches of previous scan; Scan width was 10.3 inches.

⁽³⁾ Start of scan @ end of previous scan; Scan width was 10.3 inches.

Table 10-25. Primary Tank Horizontal Weld - Plate 5 to Knuckle Scan, Knuckle Side (via Riser 031)

Scan I.D. Number (Data Sheets)	Vertical Location of Horizontal Weld Scan	Horizontal Location of Weld Scan, Plate Side (inches)	Design Nominal (inches)	Measured Average (inches)	Measured Minimum (inches)
	From ~1 in. to	0 – 12 (1)	0.938	0.935	0.913
Scan		12 – 24	0.938	0.930	0.896
"Horz. Weld	~5.1 in. below	24 – 36	0.938	0.925	0.910
Plate / Knuckle"	Plate #5 /	36 – 48	0.938	0.923	0.898
(Page Att. 3-47)	Knuckle Weld	48 – 60	0.938	0.920	0.884
		60 – 65.4	0.938	0.920	0.907
		0 – 12 ⁽²⁾	0.938	0.920	0.905
		12 – 24	0.938 0.915		0.897
		24 – 36	0.938	0.915	0.889
Scan		36 – 48	0.938	0.917	0.906
"Horz. Weld Plate /	From ~1 in. to ~5.1 in. below	48 – 60	0.938	0.920	0.898
Knuckle A"	Plate #5 / Knuckle Weld	60 – 72	0.938	0.948	0.939
(Page Att. 3-49)		72 – 84	0.938	0.947	0.920
		84 – 96	0.938	0.947	0.924
		96 – 108	0.938	0.948	0.935
		108 – 120	0.938	0.949	0.922
		0 – 12 (3)	0.938	0.948	0.929
Scan	From ~1 in. to	12 – 24	0.938	0.946	0.936
"Horz. Weld Plate /	~5.1 in. below	24 – 36	0.938	0.947	0.908
Knuckle B"	Plate #5 /	36 – 48	0.938	0.945	0.922
(Page Att. 3-50)	Knuckle Weld	48 – 60	0.938	0.964	0.926
		60 – 61.9	0.938	0.963	0.955

⁽¹⁾ Start of scan @ 3rd air slot south of north air line; Scan width was 10.3 inches.

⁽²⁾ Start of scan @ 63.7 inches of previous scan; Scan width was 10.3 inches.

⁽³⁾ Start of scan @ end of previous scan; Scan width was 10.3 inches.

11.0 EVALUATION OF INSPECTION RESULTS

The results from the inspection of tank 241-AP-101 are evaluated and compared with results of all other tank ultrasonic inspections.

11.1 TANK 241-AP-101 UT DATA EVALUATION

The UT P-scan data and T-SAFT data were interpreted by W. H. Nelson, COGEMA Engineering's Level III certified inspector. The P-scan data were also examined by J. B. Elder, an independent Level III certified NDE Inspector. Mr. Elder independently evaluated the P-scan raw data and concurred with COGEMA Engineering's interpretation (Attachment 3). The P-scan and T-SAFT data have also been evaluated by PNNL as a third party review. Their results and conclusions were found to be consistent with those described in this report. Their P-scan data review is *Ultrasonic Examination Of Double-Shell Tank 241-AP-101 - Examination Completed March 2003*, PNNL report number PNNL-14278, Rev. 0 (Attachment 5), and their T-SAFT data review is *RONDE Ultrasonic Examination of Double-Shell Tank 241-AP-101 Knuckle Region - Examination Completed April 2003*, PNNL report number PNNL-14288, Rev. 0 (Attachment 6).

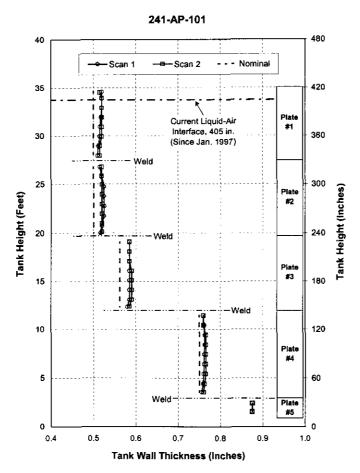
The results of the tank 241-AP-101 UT inspections (both P-scan and T-SAFT) indicated no reportable wall thinning, no pit-like indications, and no cracking. Figure 11-1 shows the "as-found" measurements of the primary tank vertical wall scans generated from the P-scan Inspection Data Sheets (Attachment 3).

Each wall thickness measurement plotted on Figure 11-1 is the average of all data collected over a 12 inch long by 15 inch wide scan area. Areas of interest for tank 241-AP-101 are the vapor space above the current liquid waste, the current liquid-vapor interface, the liquid region, and any additional historical liquid-vapor interface regions. Since January 1997, the liquid waste level has been at approximately 405 inches (33.7 feet); and during the period from December 1989 to August 1994, the level remained relatively constant at approximately 386 inches (32.2 feet). There is no evidence of any significant general thinning in any of these regions.

The UT data show that the primary tank average wall thickness values exceed the nominal values specified in the design documents. The UT data, when compared to construction specifications, drawings, standards, and codes (241-AP Double-Shell Tanks Integrity Assessment Report, Jensen 1999), reveal that the as-found condition of the tank plates and welds are all within the allowable design limits. A summary of the results associated with the areas examined is presented below.

Primary Tank Wall: Two vertical strips encompassing Plates #1 through #5 were examined. The overall average wall thickness for each plate vertical scan varied only 0.005 inches from plate to plate (for same nominal-thickness plates) and a maximum of only 0.003 inches within the same plate (for all plates). All overall plate wall averages were between 0.000 inches and 0.023 inches greater than their nominal plate thickness values. No reportable wall thinning, pitting indications or crack-like indications were found.

Figure 11-1. Scan Data Average Wall Thickness Compared to Nominal Plate Thickness



Lower Primary Knuckle Wall: A horizontal strip (19.6 feet long by approximately 12 inches wide) along the lower primary knuckle wall was examined using the P-scan system. The overall lower knuckle wall average (0.9373 inches) was virtually the same as the nominal plate thickness value (0.9375 inches). Vertical strips totaling 2.3 feet long by approximately 1 inch wide of the lower portion of the lower knuckle were examined using the P-scan transducer lined up with four different air slots. The inspections yielded wall thickness average values and minimum wall thickness values that exceeded the nominal value. No reportable wall thinning, pitting indications or crack-like indications were found using the P-scan system.

A horizontal scan (20.0 feet long) using the T-SAFT system was performed just above the lower knuckle weld, which probed the entire lower knuckle region below the transducers for circumferential cracks. No reportable crack-like indications were found using the T-SAFT system.

Primary Tank Welds: One vertical weld in each of the four lower Plates #2 through #5 was examined. No crack-like indications were found. There were also no reportable wall thinning or pitting indications found. The plate walls adjacent to the welds averaged 0.022 inches greater than to 0.002 inches less than their nominal plate thickness values.

Primary Tank Knuckle-to-Shell Weld: An approximately 20.5 feet long region of the horizontal knuckle-to-shell weld was examined. No crack-like indications were found. There were also no reportable wall thinning or pitting indications found. The plate walls adjacent to the weld averaged 0.002 inches greater than (plate side) to 0.002 inches less than (knuckle side) than their nominal plate thickness values.

11.2 DST ULTRASONIC INSPECTION DATA RESULTS COMPARISON

The following Tables 11-1 and 11-2 provide a summary of primary tank vertical wall inspection results and a comparison of primary tank wall thinning.

Table 11-1 reports the inspection results chronologically according to fiscal year (October 1 through September 30).

Table 11-1. Double-Shell Tanks Chronological Inspection Results Findings

Tank	Inspection Year (FY)	Reportable Plate Crack Indication	Reportable Plate Pitting	Reportable Plate Thinning	Reportable Weld Thinning, Pitting or Cracking	
AW-103	1997	None	None	None	None	
AN-107	1998	None	None	None	None	
AN-106	1999	None	None	None	None	
AN-105	1999	None	None	Two very minute areas of a plate (20% maximum reduction in thickness) (a)	None	
AZ-101	1999	None	None	One area of a plate (11.4% maximum reduction in thickness)	None	
AY-102	1999	None	None	None	None	
AP-107	2000	None	None	None	None	
AP-108	2000	None	None	Two minute areas of a plate (13.8% maximum reduction in thickness).	None (b)	
AW-101	2001	None	None	A pit like indication in a very minute area of a plate (16% maximum reduction in thickness).	None	
AW-105	2001	None	None	None	None	
AY-101	2001	None	Pit-like indication at historical liquid-air interface	Some pit-like indications identified as thinning	Three areas of 10% wall thinning in vertical welds	
AN-102	2001	None	None	One minute area of a plate (11% maximum reduction in thickness)	None	

(Cont. on next page)

Table 11-1. (Cont.) I	Double-Shell Tanks Chronologica	l Inspection Results Findings
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Tank	Inspection Year (FY)	Reportable Plate Crack Indication	Reportable Plate Pitting	Reportable Plate Thinning	Reportable Weld Thinning, Pitting or Cracking	
AN-101	2002	None	None	One small area of a plate (12 % maximum reduction in thickness)	Four local areas near vertical welds (14% maximum reduction in thickness)	
AW-106	2002	None	None	One small area	10.4% maximum reduction in thickness	
AY-101	2002	Not Investigated	None	72 areas of >10% wall thinning, most in the historical liquid-air interface in Plate #2 (20.2% maximum reduction in thickness)	Not Investigated	
AW-104	2002	None	None	None	None	
AW-102	2002 & 2003 ^(c)	None	None	None	None	
AN-105	2002	None	None	None	Not Investigated	
AP-101	2003	None	None	None	None	

⁽a) Based on a review of the tank 241-AN-105 data gathering technique in FY 1999, prompted by the FY 2002 results, the FY 1999 wall thinning data is considered questionable.

The inspection results in Table 11-1 show that the overall condition of the inspected tanks is satisfactory. Defects or minute reportable localized plate thinning may be due to various reasons, such as fabrication defects, construction damage or in-service corrosion.

Wall thickness data gathered from ultrasonic examination of seventeen DSTs were compared to evaluate the degree of wall thinning that may have occurred among the tanks examined. These wall thickness data do not allow a direct calculation of wall thinning, since no measurements were made of original plate thickness values at the time of construction. However, wall thickness data from ultrasonic testing may be compared to the specified nominal plate thickness. This assessment used the minimum wall thickness in each scanning area (generally 12 inch by 15 inch) from the vertical wall scans and then calculated the average for each plate using the minimum thickness values.

Table 11-2 provides a summary of wall thinning, defined as nominal plate thickness minus average minimum plate thickness⁵, by nominal plate size, and by DST examined. The negative

⁽b) Although below reporting criteria at the time, one linear crack-like indication 6 inch long by 0.142 inch deep in a nominal 0.750 inch thick plate was observed. Subsequent examination of tank 241-AP-108 in FY 2002 revealed no change in size.

⁽c) Primary knuckle examination using T-SAFT conducted in FY 2003.

Average minimum plate thickness is defined as the average of all the minimum measured thickness values for each scanning area (generally 12 inch by 15 inch) for a given plate size and DST.

values in the table indicate where the average of all minimum values of plate thickness exceeds nominal plate thickness. The table also provides the calculated average wall thinning and associated standard deviation by DST examined for all nominal plate thickness values, and by nominal plate thickness for all DSTs examined.

Tank 241-AP-101 did not exhibit any significant thinning, with only the Plate #5 minimum values averaging slightly below (0.010 inch) the nominal plate thickness of 0.875 inch.

Table 11-2. Tank Wall Thinning by Nominal Plate Size

рет	FY Examined	Wall Thinning* By Nominal Plate Size (Inches)						
DST		0.375"	0.500"	0.5625"	0.750"	0.875"	AVG	STD DEV
AN-101	2002	n/a	0.008	n/a	0.027	0.015	0.013	0.014
AN-102	2001	n/a	0.004	n/a	0.003	0.005	0.004	0.016
AN-105	1999	n/a	0.026	n/a	0.007	0.001	0.019	0.032
AN-105	2002	n/a	0.015	n/a	n/exam.	n/exam.	0.015	0.021
AN-106 ,	1999	n/a	0.006	n/a	0.015	0.012	0.009	0.009
AN-107	1998	n/a	-0.018	n/a	-0.015	0.013	-0.016	0.017
AP-101	2003	n/a	-0.008	-0.003	-0.002	0.010	-0.004	0.008
AP-107	2000	n/a	-0.011	-0.012	-0.017	-0.013	-0.013	0.008
AP-108	2000	n/a	-0.017	-0.012	-0.011	-0.005	-0.014	0.016
AW-101	2001	n/a	0.008	n/a	0.014	0.020	0.010	0.013
AW-102	2002	n/a	-0.019	n/a	-0.006	0.008	-0.014	0.012
AW-103	1997	n/a	-0.010	n/a	-0.005	0.004	-0.007	0.008
AW-104	2002	n/a	-0.036	n/a	-0.031	-0.007	-0.033	0.011
AW-105	2001	n/a	0.000	n/a	0.008	-0.003	0.002	0.018
AW-106	2002	n/a	-0.004	n/a	0.015	0.000	0.001	0.016
AY-101	2001	-0.011	0.030	n/a	0.018	0.012	0.030	0.029
AY-102	1999	-0.021	0.001	n/a	0.008	n/a	0.000	0.012
AZ-101	1999	0.021	0.027	n/a	0.020	0.003	0.024	0.011
AVG:		-0.006	0.000	-0.009	0.004	0.004		14-6-64
STD DEV:		0.020	0.024	0.008	0.020	0.012		along ba

^{*} Thinning = nominal plate size - minimum thickness n/a - not applicable; n/exam. - not examined

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12.0 FINDINGS, CONCLUSIONS, AND RECOMMENDATIONS

The findings, conclusions, and recommendations from the UT inspection of DST 241-AP-101 are listed below.

- No reportable wall thinning was detected in any of the vertical wall plate areas examined. The primary wall vertical scans (Plates #1 through #5) yielded overall average wall thickness values that equaled or exceeded the nominal wall thickness values. The minimum wall thickness values for the plates generally exceeded the nominal values. Of the 12 inch long vertical wall plate scans yielding minimums falling below the nominal values, the greatest deviation was 4.3% below the nominal (where reportable wall thinning is defined as greater than 10% below the nominal).
- No reportable wall thinning was detected in any of the lower primary knuckle areas examined. The primary knuckle horizontal scan yielded an overall average wall thickness values that was virtually the same as the nominal plate thickness value. All of the minimum wall thickness values for the knuckle horizontal scan were less than the nominal values, the greatest deviation being 7.7% below the nominal. Inspections of the lower portion of the lower knuckle using the P-scan transducer lined up with air slots yielded wall thickness average values and minimum wall thickness values that exceeded the nominal values.
- No reportable pitting indications nor any crack-like indications were detected in any of the vertical wall plates or lower primary knuckle. This includes 20 feet of the primary knuckle in which no circumferential crack-like indications were detected using both the P-scan and the T-SAFT systems. Although the P-scan system is limited to examining the upper two-thirds of the knuckle, the T-SAFT system is capable of probing the entire knuckle region for crack-like indications (from weld to weld, which includes the highest stress region).
- No crack-like indications were detected in any of the weld heat-affected zones. The primary tank vertical weld scans (Plates #2 through #5) and the knuckle-to-shell horizontal weld scan (Plate #5 to lower knuckle) yielded overall average wall thickness values that ranged from 0.002 inches below to 0.022 inches above the nominal values. There were no reportable wall thinning indications in any of the heat-affected zones, with the minimum wall thickness values ranging from 0.2% to 5.8% below the nominal values. In addition, there were no reportable pitting indications detected in any of the weld heat-affected zones.
- The absence of cracks in the plates and weld-heat-affected zones indicates that the pre-service material quality control, weld-stress relief treatment, and waste chemistry controls have been effective in preventing cracks.

 According to a recent Tank Integrity Assessment Project DST Lifecycle Schedule, tank 241-AP-101 is scheduled for its second UT examination in about eight years. Based on the results of this UT examination, it is recommended that this schedule be maintained – there is no reason to perform any near-term follow-up inspections on this tank.
 Following the second UT examination, inspection parameters such as wall thinning rates can be calculated and used to better quantify and evaluate any continual wall thinning or degradation.

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ATTACHMENT 1

AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

(COGEMA Engineering Corporation Procedure COGEMA-SVUT-INS-007.3, Rev. 1)

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AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

1.0 PURPOSE

This procedure establishes the method, equipment, and requirements for automated, direct contact, ultrasonic (UT) straight-beam, thickness measurements, angle beam flaw detection, and sizing in carbon steel waste storage tanks utilizing the "P-scan" ultrasonic imaging system.

2.0 SCOPE

2.1 Requirements

The requirements herein are applicable to weld inspection, crack detection, sizing, wall thickness measurement, and the detection of wall thinning conditions, such as pitting, erosion, and corrosion in double shell tanks from 0.100 inches to 1.0 inches in thickness. At least one side must be accessible and the component surface to be measured must be parallel with the opposite surface. The requirements are also applicable to the automated UT detection and depth sizing of surface connected planar flaws.

2.2 Scanning

Scanning is performed using remotely controlled automatic scanners.

2.3 Examinations

Examinations shall be performed from inside the annulus of the double shell tanks.

2.4 Instructions

This procedure provides the instructions for the use of Tip Diffraction Techniques including the Absolute Arrival Time Technique (AATT), and the Relative Arrival Time Technique (RATT), for the sizing of planar flaws.

2.5 Methodology

The methodology in this procedure meets the requirements as addressed in Reference 4.1 as applicable to meet the requirements for inspection of double shell tanks.

3.0 RESPONSIBILITIES

Only certified Level II or Level III ultrasonic examiners shall interpret data to determine whether it represents relevant or non-relevant indication in accordance with the applicable specification.



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AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Level III ultrasonic examiners shall review all data collected prior to issuing a final report.

4.0 REFERENCES

- 4.1 ASME Boiler & Pressure Vessel Code, Section V, Article 4, 1995 Edition.
- 4.2 COGEMA SV-CP-PRC-014, Qualification and Certification OF NDE Personnel.
- 4.3 COGEMA SVAD-PRC-001, Nondestructive Examination Administrative Procedure.
- 4.4 COGEMA SVUT-PRC-007, Ultrasonic Examination Procedure.
- 4.5 FORCE Institutes, P-scan System 4 Instruction Manual

5.0 PERSONNEL REQUIREMENTS

5.1 Personnel Qualifications

Personnel performing or supervising data acquisition or performing data analysis to the requirements of this procedure shall be qualified and certified to at least level II in ultrasonics in accordance with reference 4.2 or equivalent. In addition, they shall be trained in techniques for sizing stress corrosion cracking/planar flaws.

5.2 Certification Level

Personnel performing review for final acceptance of examination data shall be certified to at least level II in ultrasonics in accordance with reference 4.2 or equivalent.

5.3 Support Personnel

Personnel, whose responsibilities are limited to set-up, tear down, and track or scanner operation need not be certified. Such personnel shall possess sufficient knowledge of the equipment to satisfy the Level III examiner.

6.0 EQUIPMENT

6.1 Ultrasonic Instrument/Examination System



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The P-scan computerized pulse-echo ultrasonic inspection system shall be used. The system shall be equipped with a stepped gain control in units of 1dB with a dynamic range of at least 115 dB, capable of generating and receiving frequencies in the range of 0.5 to 15 MHz. The following components may be used:

PS-4	P-scan processor
Analysis computer	Off-line data analysis with P-scan analysis software
Digital Controller, WSC-2S, or other approved scan controller	Automatic scanner controller
AWS-5, AWS5-D, RUTI*	Automatic P-scan scanner
Pump	Couplant pump for P-scan system

^{*}Remote Ultrasonic Inspection (RUTI) system

6.2 Transducers

Straight-beam and angle-beam transducers with single or dual elements, with or without delay tips, may be used, provided they can be attached to and manipulated by the scanner, and can be adequately coupled to the test item with a resultant backwall signal response of at least a 2 to 1 signal-to-noise ratio. Sizes and frequencies shall be as specified for the following applications:

- 6.2.1 For high sensitivity applications such as the detection of pitting, erosion or corrosion, transducer sizes in the range of 1/4 inch to 1/2 inch, with a frequency in the range of 4.0 to 10 MHz, shall be used.
- 6.2.2 For weld inspection, detection and sizing of planar flaws that are open to the surface, angle beam transducers with a nominal angle of 45 degrees with an element size in the range of 1/4 inch to 1/2 inch, with a frequency in the range of 4.0 to 10 MHz, shall be used. Where interference from weld geometry prevents examination of the required volume with a 45-degree a 60-degree angle may be substituted.
- 6.2.3 Transducers of other angles, element sizes, modes of propagation, or frequencies outside the above ranges may be used to suit other required examination techniques.

6.3 Cables

6.3.1 Cables of any compatible type and number of connectors may be used for examination. The length shall be limited to 400 feet, or less where signal



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degradation occurs. The same cables shall be used for calibration and examination.

6.3.2 The scanner control cable for analog scanners shall be limited to 330 feet maximum. Digitally controlled scanners shall have a maximum cable length as stipulated by the manufacture's recommendation.

6.4 Couplant

- 6.4.1 Site approved water should be used as couplant for the examination.
- 6.4.2 Couplant application should be accomplished by means of an automatic couplant delivery system whenever possible. Care should be taken to use only as much water as required, as excess water in the annulus is undesirable.

6.5 User Calibration Blocks

- 6.5.1 For general thickness measurements, or the detection of pitting, erosion, or corrosion, user calibration blocks shall be made of an acoustically similar material as that being measured. A standard step block with 0.1 inch or greater increments encompassing the nominal thickness to be measured shall be used.
- 6.5.2 For weld inspection, crack detection and sizing measurements, user calibration blocks shall be made of an acoustically similar material as that being measured. A standard notched block with 0.1 inch or greater increments encompassing the nominal thickness to be measured shall be used.

6.6 Reference Blocks

Reference blocks (e.g., Rompas, IIW, DSC) utilized for beam angle exit point determination or screen width calibration shall be of similar material composition as the component under examination.

6.7 Pulse Repetition Rate

The repetition rates are set at rates such that signal wrap-around does not occur. In addition, the rates are sufficient to pulse the transducer at least six times within the time necessary to move one-half the transducer dimension parallel to the scan direction at maximum scanning speed.



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7.0 CALIBRATION

7.1 Verification of Instrument Linearity

Instrument alignment verification for screen height and amplitude control should be performed within three (3) months prior to use of the instrument or at the beginning and end of each outage period, whichever is less. Instrument linearity verification is independent of transducer or scanner characteristics. Verification with one transducer/scanner combination is valid for any other combination. The due date for alignment verification shall be recorded on the calibration sheet.

7.2 System Parameters

The system parameters used for calibration and examination should be established as outlined in Reference 4.5 as required. The system should be operated in the T-SCAN program for thickness mapping and zero degree inspection and in the P-SCAN program for crack detection, weld inspection and/or additional evaluation.

7.3 General Requirements

- 7.3.1 Calibration shall include the <u>complete ultrasonic examination system</u>. Any change in transducers, wedges, couplants, cables, instruments, recording devices, scanners, power source, or any other parts of the examination system shall be cause for system calibration check.
- 7.3.2 If a secondary ultrasonic system is to be used, it must be calibrated before the inspection is started and not removed from the examination system during the inspection or recalibration will be required.
- 7.3.3 System calibration checks and final calibration for instrument sensitivity and sweep range shall be performed on the same block used for initial calibration using at least one reflector. These checks shall be performed:
 - a) At the start and finish of each series of examinations.
 - b) At intervals not to exceed 16 hours.
 - c) When there is a change as described in 7.3.1.
 - d) If the examiner suspects a malfunction.



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- 7.3.4 If the horizontal sweep, thickness, or "Z" positions have changed more than 5 percent of the nominal thickness, void all examinations performed after the last valid calibration verification, and reexamine the voided areas.
- 7.3.5 <u>Calibration checks</u> may be performed on either a reference block or the basic calibration block, but must include a check of the entire examination system. Calibration checks may be accomplished by static or dynamic calibration.
- 7.3.6 Simulated calibration checks may be used in lieu of calibration checks where the spread of contamination or serious time constraints would result from performing a standard calibration check. Simulated calibration will use blocks, cables, or transducers of similar types and lengths as those used for testing and will be documented on the calibration data sheet. A baseline, simulated calibration shall be performed immediately after performing the initial calibration, or after a calibration check where the entire examination system is utilized. The initial simulated calibration check values are independent of the values obtained utilizing the entire examination system. The established tolerance applies to the subsequent simulated calibration checks.
- 7.3.7 During calibration, the temperature of the calibration block should be within 25 degrees of the ambient inspection temperature.
- 7.4 Calibration Process for Thickness Mapping / T-scan

The basic process for calibration is the same for thickness mapping (T-scan), weld inspection, flaw detection, and sizing. The calibration reflectors for straight beam are the backwall reflections from a step wedge. The reflectors for angle beam transducers are the notch base and tips from a notched block. The calibration process is as follows:

- 7.4.1 Select and connect the appropriate transducer(s), input the parameters, including thickness, frequency, index delay, gates, inspection method(s), and velocity. Apply the couplant to the applicable points on the calibration standard. (Select a sufficiently thin step for detection of unexpected low reading or pits and a step greater than the maximum thickness expected).
- 7.4.2 Place the transducer(s) on the calibration step nearest to the nominal thickness of the item to be examined. Adjust the gain control to produce a reflection of 80% full screen height (FSH). Input this gain level as the reference level. Obtain a response from the other calibration points, and verify that they produce an acceptable signal. Initial calibration accuracy



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- will be within +/- 0.010". in T-scan. Perform steps 7.4.1 and 7.4.2 for each physical transducer being used.
- 7.4.3 Position the transducer to produce a response from the smaller of the two (2) steps to be used for calibration. Using the scan menu, collect a reading from that step. The transducer may be removed from the scanner and remain stationary "static" while the scanner is manipulated to make a larger indication on the screen.
- 7.4.4 Position the transducer on the thicker step and collect data from that step. Using the level control, measure the thickness from each step. Adjust the system to read the correct thickness with index delay and velocity if needed.
- 7.4.5 Repeat these steps as required until the system is accurately measuring the thickness over the entire inspection range with each transducer/active inspection. During initial calibration, all intermediate steps within the inspection range should be confirmed.
- 7.4.6 The vital parameters used for the calibration shall be identical to the inspection parameters with the exceptions of file name(s), X, Y and Z ranges, reference level compensations, thickness, gates or comment parameters which may be adjusted as required.
- 7.4.7 At a minimum, readings from the thinnest and thickest calibration reflectors shall be recorded for each applicable transducer on the Automated Ultrasonic Thickness Calibration Sheet (Attachment 4).
- 7.5 Calibration Process for Weld Inspection / Crack Detection / P-scan
 - 7.5.1 Select and connect the appropriate transducer(s), input the parameters, including thickness, frequency, index delay, gates, inspection method(s), and velocity. Apply the couplant to the applicable points on the calibration standard. The 5%T notch on a 1" thick plate should be used to obtain the reference level.
 - 7.5.2 Manipulate the transducer to receive the maximum response from the reference notch. Adjust the gain control to produce a reflection of 80% full screen height (FSH). Input this value as the reference level. Obtain a response from the calibration reflector and verify that the response is within +/- 2dB.



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- 7.5.3 Position the transducer to produce a response from the reference reflector. Using the scan menu, collect data from that notch. The transducer may be removed from the scanner and remain stationary "static" while the scanner is manipulated to make an indication on the screen.
- 7.5.4 Use the level control to determine the peak amplitude and the position of the indication at the peak amplitude. Use index delay and velocity (if required) to adjust the system to plot the reflectors in the appropriate positions. The ID notch should plot on the ID at or near the peak amplitude.
- 7.5.5 Repeat steps 7.5.2 through 7.5.3 as required for each transducer until the system is calibrated.
- 7.5.6 The vital parameters used for the calibration shall be identical to the inspection parameters with the exceptions of file name(s), X, Y and Z ranges, reference level compensations, thickness, gates or comment parameters which may be adjusted as required.
- 7.5.7 The calibration reflector(s) and response shall be recorded for each applicable transducer on the Automated Ultrasonic P-Scan Calibration Sheet (Attachment 7).
- 7.6 Sizing Calibration for Tip Diffraction Techniques (AATT, RATT)
 - a) Select an appropriate transducer.
 - b) Select a sizing calibration block of similar thickness and material containing at least two notches of known depths.
 - c) For the AATT technique, set at least two gates, to cover the entire area of interest. The first gate in the first leg, ending just before the ID. Position the transducer on the calibration block. Alternately peak the shallow and deep signals from the notch tips (see Attachment 6). Using the index delay and velocity controls, adjust the system until the system correctly reads the remaining ligament with the "Z" cursor.
 - d) For the RATT technique, the system mode should be set to A-SCAN.

 Manipulate the transducer until signals are obtained from the shallow notch tip and the notch base simultaneously (see Figure 2, Attachment 6). Using the index delay and velocity, adjust the distance between the two signals to read the actual reflector depth in inches. Repeat the same process on the deep



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notch. Alternate this procedure until the screen/system represents a desirable linear depth screen in inches.

e) Save the calibration, and record this data on the Automated Ultrasonic P-Scan Calibration Sheet (Attachment 7).

8.0 EXAMINATION

8.1 Surface Condition

- 8.1.1 The surface from which measurements are to be taken should be free of loose scale, unbonded coating, heavy oxidation, weld spatter, or other material which may interfere with movement of the transducer or the transmission of sound into the material.
- 8.1.2 A surface finish of 250 RMS or better should be provided. The requesting organization must approve the use of any base material preparation process, which may reduce the thickness below the allowable tolerance.

8.2 Extent of Examination

The location of the areas to be measured and/or the number of scans to be performed shall be designated by the applicable work instructions. The location, scan numbers, and reference points of all scans shall be recorded on the applicable data sheets. See attachment 1 for minimum examination volume and beam direction for weld inspection.

NOTE: Additional scan areas will not require revision to this procedure.

8.3 Flaw Location

When performing examinations to detect planar flaws, angle beam transducers shall be used. Calibration is performed as in Section 7.5. All angle beam examinations shall be performed in P-scan.

8.4 Ultrasonic Measurement

User calibration shall have been completed per the applicable requirements of Section 7.0 prior to performing any of the examinations.

8.4.1 The amplitude of the first back reflection obtained from the item to be examined shall be adjusted as necessary using the Transfer Correction to



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maintain approximately the same amplitude as that used for calibration. The dB value obtained with straight beam transducer should be recorded on the report. This value should be considered during analysis of P-scan angle beam data also.

- 8.4.2 Transducer overlap between passes shall be a minimum of 50% of the element size. Scanning speed shall not exceed 6 inches per second.
- 8.4.3 Should measurements be observed larger or smaller than the range calibrated for in Section 6.0, check the calibration for accuracy in the encountered thickness range. If the calibration is accurate in this range, amend the calibration sheet and continue the examination. If the calibration is <u>not</u> within the tolerance allowed in the spec, then <u>recalibrate</u> and <u>rescan</u> all areas where readings were encountered outside the originally calibrated range.

8.5 Limitations and Precautions

- 8.5.1 Care must be taken to ensure the transducer face is flush with the examination surface during scanning.
- 8.5.2 When it is necessary to determine the origin of mid-wall indications, a 4MHz shear wave transducer(s) may be used in the P-Scan program to detect pit openings or perpendicular connections between laminar indications.

8.6 Recording

Upon completion of each scan area, the data file(s) shall be recorded on a disk. All measurements within the predetermined gated area are stored, along with the text information with each file.

8.7 General Sizing Guidelines

8.7.1 It is recognized that, of the methods of sizing described in this procedure, no one technique is completely accurate in sizing all flaws in all thicknesses. By using complementary methods, however, a realistic approximation of the flaw depth can be obtained.



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- 8.7.2 The method of sizing pits is primarily utilizing a zero degree dual element transducer. The 45-degree shear wave transducers may be used to confirm qualitatively the depth of the pit.
- 8.7.3 When sizing crack-like indications, the entire flawed area shall be scanned with the imaging mode. The entire flaw length shall be evaluated. It is recommended that A-Scans be recorded at the <u>deepest</u> location of the flaw. The primary technique for sizing crack-like indications is the high frequency, 45 degree shear wave transducer utilizing the Absolute Arrival Time Technique (AATT). The dual element, straight beam may be used as a complimentary technique.
- 8.7.4 Additional sizing technique sequences may be utilized if the primary techniques identified prove to be indeterminable.
- 8.8 Sizing with Tip Diffraction Techniques (AATT, RATT)
 - 8.8.1 The AATT technique uses shear waves to obtain a diffracted echo (satellite pulse) from the flaw tip (see Figure 1 Attachment 6). The RATT technique uses shear wave reflected signals from both the flaw tip and the flaw base (see Figure 2 Attachment 6). Both techniques can be utilized using the same transducer.

a) AATT Technique

Locate the deepest extremity of the flaw and maximize the signal from the flaw tip. The distance to the flaw tip represents the remaining material ligament from the outside surface. To determine the relative through wall flaw depth, subtract this dimension from the local material wall thickness.

b) RATT Technique

Locate the deepest extremity of the flaw, and obtain a signal from the flaw base. Manipulate the transducer until the doublet (flaw base and tip signal appearing simultaneously) is observed. These signals do not have to be peaked, as the doublet separation directly indicates the relative through wall depth. To determine remaining material ligament, subtract the relative through wall depth measurement from the local material wall thickness.

8.8.2 Other sizing techniques or variations to the techniques may be used with the approval of the UT Level III. Such approval, signature and a



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description of the technique shall be recorded in the "Remarks" column on the Ultrasonic Sizing Calibration Sheet (Attachment 7).

9.0 EVALUATION

9.1 Relevant Indications

Relevant indications including pitting, thinning and crack-like indications along with the minimum thickness reading in the area of interest shall be recorded and used for evaluation per Paragraph 9.2.

- 9.1.1 P-scan data shall be evaluated to a sensitivity of 20% reference level (-14dB). All crack-like indications are recordable regardless of amplitude.
- 9.1.2 T-scan data shall be evaluated utilizing all available images to detect and evaluate indications.
- 9.1.3 Reportable indications shall be evaluated by Level III personnel prior to final report submittal.

9.2 Reporting/Special Criteria

Reporting and special notification criteria are noted in Section 9.8.

9.3 Statistical Information

The statistical information (Minimum and Mean thickness) provided under "Setup" pages 1 & 2 of the post-processing software should be reported for each "Part" of a given scan location. Where data noise invalidates these values, the analyst should determine the values using the level control.

9.4 Printouts

Printouts should be made in accordance with the customer's request. In absence of further direction, both the merged set-up pages and the merged image, adjusted to show the minimum thickness, shall be printed at a level that best shows the wear patterns or at Nominal T - 12.5%, whichever provides the most useful information. P-scan data should be printed with the level control set at 20% reference level (-14dB).



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9.5 Recording Crack Size

- 9.5.1 All flaw sizing data acquired should be used to determine the flaw depth. This data shall be reported individually for each flaw and shall include all data necessary to achieve the best accuracy of flaw depth.
- 9.5.2 If, during sizing, a <u>flaw length other than that reported during the detection examination</u> is measured, or other discrepant conditions occur, record the corrected lengths, locations. or distances on the Ultrasonic P-scan Data Report (Attachment 8) in the spaces provided.
- 9.5.3 If, during sizing, the area is determined <u>not to be flawed</u>, and the resultant reflector(s) is due to component/weld geometry or metallurgical structure, the true origin (e.g., root, mismatch, etc.) shall be documented and substantiated on the Ultrasonic P-scan Data Report.

9.6 Scanning Limitations

Record all limitations due to weld configurations, obstructions, single side access restrictions, etc., in the remarks section on the applicable Ultrasonic Data Report. Details as to specific length or area in relation to L (X) and/or W (Y) reference points should be recorded.

9.7 Flaw Evaluation

Reportable indications shall be evaluated by Level III personnel prior to final report submittal.

9.8 Reporting Levels

All indications which meet or exceed the following conditions shall be reported to the project cognizant engineer.

- a) Pit depth exceeds 25% of the wall thickness.
- b) Wall thinning exceeds 10% of the wall thickness.
- c) Surface crack depths exceeding 0.18 inches.



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

10.0 REPORTS

10.1 Thickness Data Reports

An Automated Ultrasonic Thickness Data Report (Attachment 3) shall be prepared for each examination or series of examinations performed. This report shall include identity of equipment, the thickness measurements obtained, and should be referenced to the calibration sheet.

10.2 Calibration Reports

An Automated Ultrasonic Examination Calibration Sheet (Attachment 4) shall be prepared for each examination or series of examinations performed. This report shall include the materials and equipment used for examination.

10.3 Sketch Sheets

An Automated Ultrasonic Examination Sketch Sheet (Attachment 5) should be prepared for each examination or series of examinations performed. This report should include identity of scanning equipment and a sketch of the component or item examined, identifying scan locations, including dimensions, reference points, and grid locations, where applicable.

10.4 Sizing Data Reports

An Ultrasonic Sizing Data Report (Attachment 8) shall be completed only when cracking is detected. Each report shall be related to the applicable Automated Ultrasonic Examination Calibration Sheet(s).

10.5 Cover Sheets

Whenever several locations are being examined on the same conponent an Automated Ultrasonic Examination Report Cover Sheet (Attachment 1) and an Automated Ultrasonic Thickness Report Summary Sheet (Attachment 2) should be completed.

10.6 Final Reports

Final reports are to be distributed and maintained in accordance with the applicable contract.



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

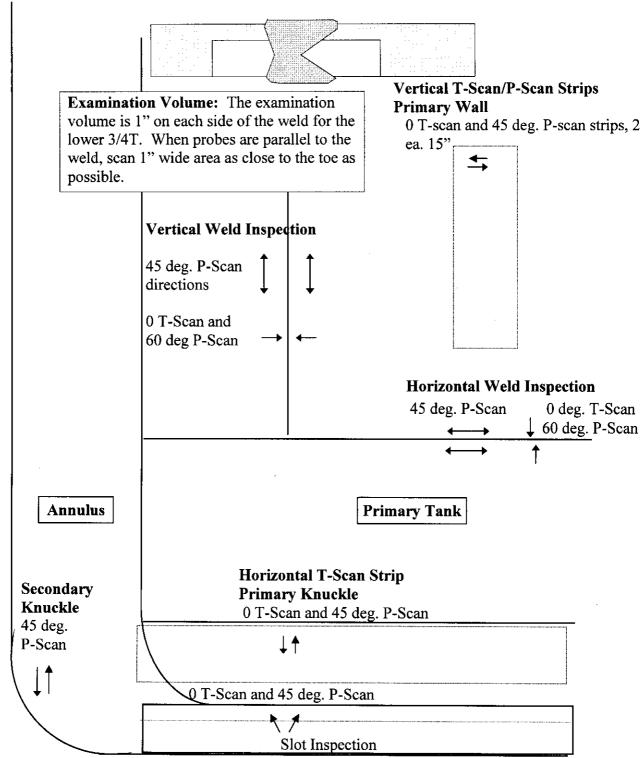
11.0 ATTACHMENTS

- 11.1 Attachment 1: Examination Volume, Minimum Beam Directions and Extent of Examination
- 11.2 Attachment 2: Sample Automated Ultrasonic Thickness Data Report
- 11.3 Attachment 3: Sample Automated Ultrasonic Thickness Calibration Sheet
- 11.4 Attachment 4: Figure 1: Absolute Arrival Time Technique (AATT) Figure 2: Relative Arrival Time Technique (RATT).
- 11.5 Attachment 5: Sample P-scan Calibration Data Sheet
- 11.6 Attachment 6: Sample Ultrasonic P-scan Data Report



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 1: Examination Volume, Minimum Beam Directions and Extent of Examination



SECONDARY BOTTOM

0 deg. T-Scan



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 1 (continued): Extent of Examination

Primary Tank Wall

<u>Vertical Strips</u> - Examine a vertical strip 30" x 35 feet long of the primary wall between the upper haunch transition and the lower knuckle for pits, cracks and wall thinning. Axial cracks on the tank inner wall surface shall be detected and sized. The vertical strip may be comprised of one or more strips whose total width is equal to 30 inches.

Weld Areas - Examine 20 feet of horizontal weld area (heat affected zone), at tank to knuckle weld. Examine one ~10 foot section of vertical weld joining the lowest shell course plates and one ~10 foot section of vertical weld joining the next to lowest shell course plates. Axial and circumferential cracks on the tank inner surface shall be detected and sized.

Primary Tank Knuckle

Examine 20 feet of the primary tank lower knuckle in the circumferential direction to detect and size cracking in the circumferential direction and to detect pits and wall thinning. The area to be examined is from the weld joining the transition plate with the knuckle to the furthest reach of the transducer assembly that is allowed by geometric constraints.

Secondary Tank

<u>Secondary Tank Lower Knuckle</u> – Examine a 20 foot length of the secondary tank knuckle over the entire area of the knuckle for the presence of circumferential cracks.

Secondary Tank Bottom – Examine the secondary tank bottom over an area of 10 ft^2 to detect and measure thickness and pits.

Primary Tank Bottom

Examine the primary tank bottom for pits, wall thinning and cracks oriented in the circumferential direction (perpendicular to the air channels) in 16 air channels. The tank bottom is to be examined for a distance of 12 feet towards the tank center, starting seven inches inboard of the outside radius of the tank cylindrical section. The primary tank bottom scan head is designed to examine the accessible area in the air channel in one pass through the channel.



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 2: Sample Automated Ultrasonic Thickness Data Report 4/00 **AUTOMATED ULTRASONIC THICKNESS DATA REPORT** EXAM START EXAM END JOB# SYSTEM LOCATION COMPONENT ID **EXAMINATION SURFACE** NOM, THICKNESS OD ID PAINTED CALIBRATED RANGE CONFIGURATION ٥F REF. LEVEL CORRECTION (TRANS. CORR) CIRCUMFERENCE/TOTAL LENGTH EXAMINED DB CONDITION PROCEDURE REV MATERIAL TYPE SS CS OTHER FILE NAME/ITEM# TRANSDUCER ☐ DUAL ☐ SGL ☐ ODEG ☐ ANGLE SCAN WIDTH Xo REF. POINT (Lo) Yo REF. POINT (Wo) X START Y START Y STOP MIN. THK, AREA COMMENTS PART#/ X STOP AVE. INDICATION THK. R. LIG. REPORTABLE **SUMMARY** REMARKS Examiner Analyst Reviewer Page Level ___ Date____ Level ___ Date____ Level ___ Date____ ____ of ___



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 3: Sample Automated Ultrasonic Thickness Calibration Sheet

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SOFTWARE VER		THICKNE	SS	MATERIAL	MATERIAL								
LINEARITY DUE DATE							NCE	BLOCK TEMP		PYRO SN.	····		
SCANNER TYPE		\L#	COUPLA	NT		°F	BATCH#						
SCANNER CABL	.E					CABLE LI	ENG	STH	CABLE #	L			
SIGNAL CABLE					•	CABLE LI	ENG	STH	CABLE #				
	RANSDUCER AKE	MOD	EL	FREQ.	SIZE	SERIAL#	#	GATE EVAL METHOD	ANGLE	WEDGE TYPE	IMAGE		
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REMARKS								******					
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Flaw Tip and Base Signals

AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 4: Absolute Arrival Time Technique (AATT) & Relative Arrival Time Technique (RATT)

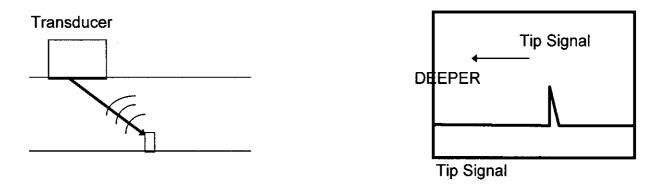


Figure 1. Absolute Arrival Time Technique



Figure 2. Relative Arrival Time Technique



AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 5: Sample P-scan Calibration Sheet

4/00 AUTOMATED ULTRASONIC P-SCAN CALIBRATION																	
						SHI	EET_										
LOCATION SYSTEM								1	CALIBRATION BLOCK								
PROCEC	PROCEDURE								THICKNESS MATERIAL								
UT SYSTEM SERIAL #								F	REFERENCE BLOCK								
SOFTWARE VERSION REV.							1	THICKNESS			MATERIAL						
LINEARITY DUE DATE							F	REFERENC	E BLOCK TEMP)F	PYRO SN.						
SCANNER TYPE SERIAL #								7	COUPLANT	 		.•	BATCH#				
SCANNE	R CAB	LE							CABLE LEN	GTH	-	CABLE #					
SIGNAL	CABLE							7	CABLE LEN	GTH		CABLE #					
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AUTOMATED ULTRASONIC EXAMINATION FOR CORROSION AND CRACKING

Attachment 6: Sample P-scan Data Report 4/00 **ULTRASONIC P-SCAN DATA REPORT** LOCATION SYSTEM **EXAM START** EXAM END JOB# EXAMINATION SURFACE
OD OD ID PAINTED
CALIBRATED RANGE COMPONENT ID CONDITION CONFIGURATION TO TEMP ٥F CIRCUMFERENCE/TOTAL LENGTH EXAMINED REF. LEVEL CORRECTION (TRANS, CORR) DB PROCEDURE REV MATERIAL TYPE SS CS OTHER TRANSDUCER FILE NAME/ITEM# ☐ DUAL ☐ SGL ☐ ODEG ☐ ANGLE Xo REF. POINT (Lo) Yo REF. POINT (Wo) SCAN WIDTH SIZING METHOD ANGLE REFERENCE CAL. SET-UP SHEET 1 45/60 DEGREE SHEAR AATT 3 RATT **DUAL 0 DEGREE** INDICATION INFORMATION IND METHOD WELD DEPTH MAX X1 LENGTH X2 <u>Y1</u> WIDTH Y2 INDICATION SIDE R. LIG. **AMP** TYPE REMARKS Examiner Analyst Reviewer Page ___ of ___ Level ___ Date____ Level ___ Date____ Level ___ Date

ATTACHMENT 2

ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

(COGEMA Engineering Corporation Procedure COGEMA-SVUT-INS-007.5, Rev. 0)

UNCONTROLLED COPY

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ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

1.0 PURPOSE

This procedure establishes the method, equipment, and requirements for the direct contact, ultrasonic angle beam flaw detection and sizing, in the knuckle region of Hanford's carbon steel double shell tank's (DSTs) utilizing the Remotely Operated Nondestructive Examination (RONDE) ultrasonic imaging system.

2.0 SCOPE

2.1 Requirements

The requirements herein are applicable to examination of the knuckle region of Hanford's DSTs utilizing the RONDE ultrasonic imaging system. The RONDE system provides ultrasonic detection and sizing of surface connected planar flaw (i.e. cracks) that are oriented circumferentially around the tank in the knuckle region.

2.2 Scanning

Scanning is performed using a remotely controlled scanner.

2.3 Examinations

Examinations shall be performed from inside the annulus region of the DSTs.

2.4 Instructions

This procedure provides the instructions for the use of the RONDE system in the pitch-catch mode for detection of planar flaws oriented circumferentially in the knuckle region of the DSTs and in the Tandem SAFT (T-SAFT) mode for depth sizing of planar flaws oriented circumferentially in the knuckle region of the DSTs.



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

2.5 Methodology

The methodology in this procedure meets the applicable requirements addressed in Reference 4.1 as applicable to meet the requirements for inspection of the double shell tank knuckle region.

3.0 RESPONSIBILITIES

Only certified Level II or Level III ultrasonic examiners shall interpret data to determine whether they represent relevant or non-relevant indications in accordance with the applicable specification. Level III ultrasonic examiners shall review all data collected prior to issuing a final report.

4.0 REFERENCES

- 4.1 ASME Boiler & Pressure Vessel Code, Section V, Article 4, 1995 Edition.
- 4.2 COGEMA SVCP-PRC-014, Qualification and Certification of NDE Personnel.
- 4.3 COGEMA SVAD-PRC-001, Nondestructive Examination Administrative Procedure.
- 4.4 COGEMA SVUT-PRC-007, Ultrasonic Examination Procedure.
- 4.5 RONDE Instruction Manual

5.0 PERSONNEL REQUIREMENTS

5.1 Personnel Qualifications

Personnel performing or supervising data acquisition or performing data analysis to the requirements of this procedure shall be qualified and certified to at least Level II in ultrasonics in accordance with reference 4.2 or equivalent. In addition, they shall be trained in techniques for sizing stress corrosion cracking/planar flaws using SAFT/T-SAFT.



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

5.2 Certification Level

Personnel performing review for final acceptance of examination data shall be certified to at least Level II in ultrasonics in accordance with reference 4.2 or equivalent.

5.3 Support Personnel

Personnel, whose responsibilities are limited to set-up, tear down, and track or scanner operation need not be certified. Such personnel shall possess sufficient knowledge of the equipment to satisfy the Level III examiner.

6.0 EQUIPMENT

6.1 Ultrasonic Instrument/Examination System

The RONDE ultrasonic system shall be used for the examination of the knuckle region of the Hanford DST's. The system shall be equipped with a stepped gain control in units of 1 dB with a range of at least 75 dB, capable of generating and receiving frequencies in the range of 0.5 to 5 MHz. The following components may be used:

RITEC	Pulser/Receiver
Intel P4/2.5 GHZ	Acquisition Computer
Compumotor/Precision Motion Control	Stepper Motors and Control
GXS-MC-2600	Magnetic Wheel Crawler
Pump	Couplant Pump for RONDE System
Dell	Data Acquisition and Analysis
	Computers

6.2 Transducers

Angel beam transducers that produce shear waves at 70 degrees shall be used for the knuckle region inspection. The transducer diameter shall be approximately 0.5 inches, with a center frequency of approximately 3.5 MHz.



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

6.3 Cables

Cables of any compatible type and number of connectors may be used for the examination. The length of the cables between the tank top electronics enclosure and the scanning crawler should not be greater than 100 feet. The length of cables between the tank top electronics enclosure and the control trailer should not exceed 425 feet.

6.4 Couplant

- 6.4.1 Site approved water should be used as couplant for the examination.
- 6.4.2 Couplant application should be accomplished by means of an automatic couplant delivery system whenever possible. Care should be taken to use only as much water as required, as excess water in the annulus is undesirable.

6.5 User Calibration Blocks

For crack detection and sizing measurements, user calibration blocks shall be made of an acoustically similar material as that being measured.

6.6 Reference Blocks

Reference blocks (e.g. Rompas, IIW, DSC) utilized for beam angle exit point determination or screen width calibration shall be of similar material composition as the component under examination.

6.7 Pulse Repetition Rate

The repetition rates are set at rates such that signal wrap-around does not occur.

7.0 CALIBRATION

7.1 Verification of Instrument Linearity

Instrument alignment verification for screen height and amplitude control linearity should be performed within <u>three (3) months</u> prior to use of the instrument or at the beginning and end of each outage period, whichever is less. Instrument linearity verification is independent of transducer or scanner characteristics. Verification with one



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

transducer/scanner combination is valid for any other combination. The due date for alignment verification shall be recorded on the calibration sheet.

7.2 System Parameters

The system parameters used for calibration and examination should be established as outlined in Reference 4.5 as required.

7.3 General Requirements

- 7.3.1 Calibration shall include the complete ultrasonic examination system. Any change in transducers, wedges, couplants, cables, instruments, recording devices, scanners, power source, or any other parts of the examination system shall be cause for system calibration check.
- 7.3.2 System calibration checks and final calibration for instrument sensitivity and sweep range shall be performed on the same block used for initial calibration using at least one reflector. These checks shall be performed:
 - a) At the start and finish of each series of examinations.
 - b) At intervals not to exceed 16 hours.
 - c) When there is a change as described in 7.3.1.
 - d) If the examiner suspects a malfunction.
- 7.3.3 During calibration, the temperature of the calibration block should be within 25 degrees Fahrenheit of the ambient inspection temperature.
- 7.4 Calibration Process for Knuckle Crack Detection and Sizing
 - 7.4.1 Select and connect the two appropriate transducers (X1 and X2). Verify the parameters, including thickness, frequency, and velocity. Place the SAFT/T-SAFT Scanning Bridge on the calibration fixture. Apply the couplant to the applicable point on the calibration standard. The 10%T notch on a 0.875-inch thick plate should be used to obtain the reference level.
 - 7.4.2 Assure transducers are in the park position. Translate X1 and X2 transducers one inch to the start of scan sequence. Position gain control knob to 20 dB. Acquire one 10-inch line of data. Envelope detect and



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

project this data file. Utilizing the SAFT Analyses code, record the amplitude from the 10% notch. For later amplitude calibration checks, verify that the amplitude is within \pm 3dB. Also record the distance between the 10% notch and the end of the plate signal. Verify that this distance is within \pm 0.1 inch of the calibration standard.

- 7.4.3 The vital parameters used for the calibration shall be identical to the inspection parameters with the exception of file names, X, Y, and Z ranges, reference level compensations, thickness, velocity, or comment parameters, which may be adjusted as required.
- 7.4.4 The calibration reflector response and distance between notch and end of plate shall be recorded for each transducer pair on the SAFT/T-SAFT Ultrasonic Examination Calibration Sheet (Attachment 2).

8.0 EXAMINATION

8.1 Surface Condition

- 8.1.1 The surface from which measurements are to be taken should be free of loose scale, unbonded coating, heavy oxidation, weld spatter, or other material, which may interfere with movement of the transducer or the transmission of sound into the material.
- 8.1.2 A surface finish of 250 RMS or better should be provided. The requesting organization must approve the use of any base material preparation process, which may reduce the thickness below the allowable tolerance.

8.2 Location of the Scanning Bridge

The location of the scanning bridge is critical in providing consistent and repeatable data acquisition. Location of the lower feet of the scanning bridge just below the upper knuckle weld is the desired position.

8.3 Extent of Examination

See Attachment 1 for examination parameters of the knuckle region. The location, scan numbers, and reference points of all scans shall be recorded on the applicable data sheets.



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

8.4 Ultrasonic Measurement

User calibration shall have been completed per the applicable requirements of Section 7.0 prior to performing any of the examinations.

- 8.4.1 Transducer overlap between passes shall be a minimum of <u>50%</u> of the element size for planar flaw detection and sizing. Scanning speed shall not exceed <u>6 inches</u> per second.
- 8.4.2 Should measurements be observed larger or smaller than the range calibrated for in Section 7.0, check the calibration for accuracy in the encountered thickness range. If the calibration is accurate in this range, amend the calibration sheet and continue the examination. If the calibration is <u>not</u> within the tolerance allowed in the spec, then <u>recalibrate</u> and <u>rescan</u> all areas where readings were encountered outside the originally calibrated range.

8.5 Limitations and Precautions

8.5.1 Care must be taken to ensure the transducer face is flush with the examination surface during scanning.

8.6 Recording

Upon completion of each scan area, the data file(s) shall be saved on the hard drive.

8.7 Flaw Detection and Location

Flaw detection and location shall be performed using the pitch-catch mode. Data is analyzed to provide the detection of the planar flaw, location, and length sizing in the knuckle region.

8.8 General Sizing Guidelines

8.8.1 T-SAFT provides a means for sizing the depth or through-wall dimension of vertically oriented planar defects.



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

- 8.8.2 T-SAFT uses a transmitting and receiving transducer pair in a pitch-catch arrangement.
- 8.8.3 When sizing planar defects, the entire flawed area shall be scanned in the T-SAFT mode and evaluated.
- 8.9 Sizing Utilizing the T-SAFT Technique
 - 8.9.1 The peak response from the corner trap of the planar flaw is used to initially set up the T-SAFT scanning. Location of this corner trap is found using the pitch-catch data.
 - 8.9.2 For T-SAFT data acquisition, the two tandem transducers are positioned side by side at the peak (corner trap) response location.
 - 8.9.3 The transmit and receive transducers are moved in opposite directions approximately 4 inches (or as much as possible) prior to initiating the T-SAFT scan.
 - 8.9.4 The tandem data acquisition begins by scanning the two transducers towards each other, up to the mid-point of the scan (corner trap location) and continuing way from each other, to the end of the scan line. Once the scan line is complete, the pair of transducers returns to their start positions, are both incremented circumferentially (around tank), and start the next scan line.
 - 8.9.5 Flaw depth is determined as half the distance from the upper half amplitude point to the lower half amplitude point in the B-scan views. The half amplitude points correspond to the -6dB points in the appropriate image.
 - 8.9.6 Flaw length is determined by the loss of signal at the -10dB point from the pitch-catch corner trap signal.

9.0 EVALUATION

- 9.1 Relevant Indications
 - 9.1.1 All crack-like indications are considered relevant and shall be recorded.



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

- 9.1.2 Reportable indications shall be evaluated by Ultrasonic Level III personnel prior to final report submittal.
- 9.2 Reporting/Special Criteria

Reporting and special notification criteria are noted in Section 9.8.

9.3 Printouts

Printouts of ultrasonic data should be made in accordance with the customer's request.

9.4 Recording Crack Size

All flaw sizing data acquired should be used to determine the flaw depth. This data shall be reported individually for each flaw and shall include all data necessary to achieve the best accuracy of flaw depth.

9.5 Scanning Limitations

Record all limitations due to weld configurations, obstructions, single side access restrictions, etc., in the remarks section on the SAFT/T-SAFT Ultrasonic Examination Data Report.

9.6 Flaw Evaluation

Reportable indications shall be evaluated by Ultrasonic Level III personnel prior to final report submittal.

9.7 Reporting Levels

All indications which meet or exceed the following conditions shall be reported to the project cognizant engineer.

Surface crack depths exceeding 0.10 inches.



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

10.0 REPORTS

10.1 Calibration Reports

A SAFT/T-SAFT Ultrasonic Examination Calibration Sheet (Attachment 2) shall be prepared for each examination or series of examinations performed. This report shall include the materials and equipment used for the examination.

10.2 Sketch Sheets

A SAFT/T-SAFT Ultrasonic Examination Knuckle Sketch Sheet (Attachment 4) should be prepared for each examination or series of examinations performed. This report should include identity of scanning equipment and a sketch of the component or item examined, identifying scan locations, including dimensions, reference points, and grid locations, where applicable.

10.3 Ultrasonic Data Reports

A SAFT/T-SAFT Ultrasonic Examination Data Report (Attachment 3) shall be completed to document each examination. Each report shall be related to the applicable SAFT/T-SAFT Ultrasonic Examination Calibration Sheet(s).

10.4 Final Reports

Final reports are to be distributed and maintained in accordance with the applicable contract.

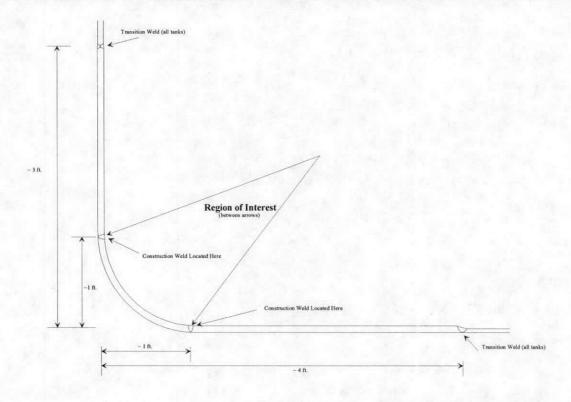
11.0 ATTACHMENTS

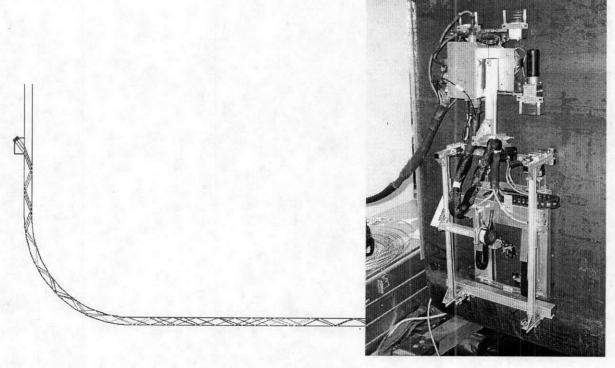
- 11.1 Attachment 1: Examination Parameters of the Knuckle Region
- 11.2 Attachment 2: SAFT/T-SAFT Ultrasonic Examination Calibration Sheet
- 11.3 Attachment 3: SAFT/T-SAFT Ultrasonic Examination Data Report
- 11.4 Attachment 4: Knuckle Sketch Sheet



ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

ATTACHMENT 1: EXAMINATION PARAMETERS OF THE KNUCKLE REGION







ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

ATTACHMENT 2: SAFT/T-SAFT ULTRASONIC EXAMINATION CALIBRATION SHEET

SAFT/T-SAFT ULTRASONIC CALIBRATION SHEET													
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SOFTWARE VE	RSIO	N	RE	REV			THICKNESS				MATERIAL		
LINEARITY DU	E DA	TE		<u> </u>			ERENCE	BLOCK TEM	P P	PYRO SN.			
SCANNER TYP	E		SE	SERIAL#			PLANT	Г	E	BATCH #			
SCANNER CAL	LE					CAB	LE LENC	ЭТН	10	CABLE #			
SIGNAL CABL	E					CAB	LE LENC)TH		CABLE #			
				TRANSDUC	ER INF	ORM	ATION						
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ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

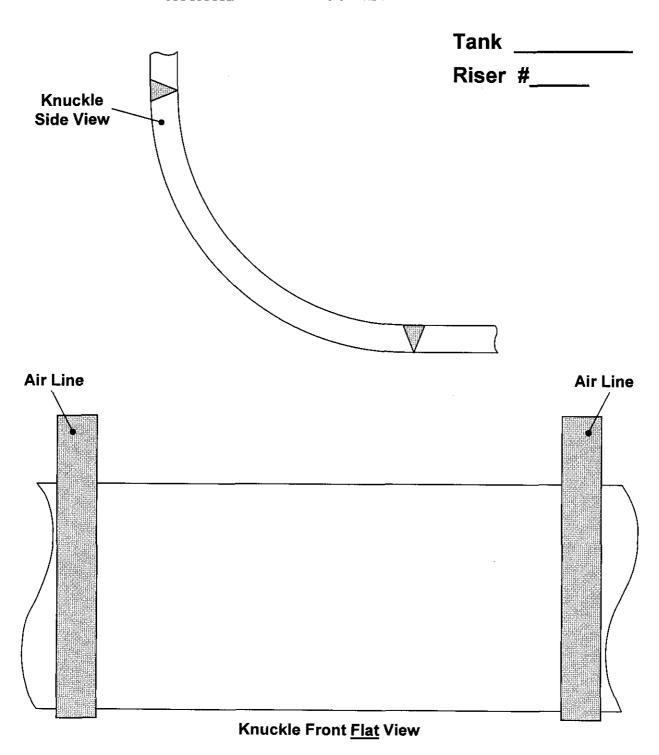
ATTACHMENT 3: SAFT/T-SAFT ULTRASONIC EXAMINATION DATA REPORT

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ULTRASONIC EXAMINATION OF THE KNUCKLE REGION

ATTACHMENT 4: KNUCKLE SKETCH SHEET



ATTACHMENT 3

COGEMA "AUTOMATED ULTRASONIC THICKNESS DATA REPORT SHEETS"

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ATTACHMENT 3

COGEMA "AUTOMATED ULTRASONIC THICKNESS DATA REPORT SHEETS"

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1	VERT.	WALL	1 PLAT	<u> </u>	X 1 E	JUAL SG	L 53. 00E0	S 🗆 A	NGLE
Above Ho	RZ. weld	* Q REF	POINT (VS)	732	SCAN V	HTOIY	15!	,	
PART#/ NDICATION	X START	X STOP	Y START	YSTOP	AVE. THK.	MIN. THK, R. LIG.	AREA REPORTAS	BLE	MAX. THK.
0-12			:		.510"	501"			,525
2-24	<u> </u>				512"	.507"			.520"
4.36					.515"	. 509"			.525"
6.48					.516"	.507"			.525
18-60			u-i	•	518"	.509"			. 530
0-72					. 520"	,510"			,520'
72-84					,520	· 511"			5 30"
34-87.9					520	.5091			. 5 30
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evel 7	ate ID tolo	7	Level	Date	6/02	evel	Dale		_ of

4/00				DAT	ONIC A REF	P-SCAN PORT					Ri	SC7 #	3 1
LOCA	TION EAST T	ank Ca	SYS	TEM 🚡	<u> 72</u>	_U		START		EXAM EN		8# 03-4 1	
COM	ONENT ID		SIX Q	 ,	-31		EXAM	NATIO	OBZO N SURFACE	:	CON	DITION	
CÓNE	IGURATION		TO				CALIS	OD [ID DF	PAINTED		TEMP	
CON	·			• 71	ate			0"	To 1.4	414"		مسك	¢۴
CIRC	JMFERENCE/	TOTAL LENG	TH EXAMINE	ر ا	7.8	<i>(</i> 1	REF.	LEVEL C	ORRECTIO	N (TRANS	S. CORR)	ds	OB
COS	EDURE EMA-S	VUT- I	NS-0			REV	□ ss	RIAL TY	CS OTHE	R _ A	0 M. T/		
FILE	NAME/ITEM#	VCO	T. WA!	112	ATE	. 1	TRAN	SDUCEI	R M⊠dsci	ET ODEG	☐ AN	GLE 46°	
X ₀ RE	F. POINT (Lo)		44	REF POIN	T (Wo)		SCAN	WIDTH	1 S			<u> </u>	
L Ale	SIZING ME	ETHOD	30 T	NGLE	A K	EFERENCE C	AI SHE	FT T			SET-UP		
1 .	45/60 DEGR			·OLL		LI LINCE C	, .L. OI IL				<u> </u>		
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	RATT					· . ·,							•
	DUAL 0 DEC	SREE										~~~~~	
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DNI	METHOD	WELD SIDE	DEPTH R. LIG	MAX AMP	X1_	LENGTH	X2	Y1	WID	TH Y	′2	INDICA TYPE	TION
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4/00	AUI		ULTRASON		NESS				
LOCATION _		I SYSTEN	ATA REPO	K!	1 5000	CTARY	EXAME	Riser	31
200 EAST	TANK FA		" <i>PSP</i> -	ų	EXAM:	SIARI 2			
COMPONENT ID	101-	AP			EXAMI	NATION SURF.	ACE	NO	M. THICKNESS 500"
CONFIGURATION		70	1 1-		CALISA	ATED RANGE			TEAU?
CIRCUMFERENC	EMOTAL LENGT	HEYALINEO	Plate		Dec 1	S TO	1,0"	5 CO22)	Amb. of
			89,7	, <i>n</i>	Mer. C	EVEL CORNEC	TION (1150N	3. COM	Ø DB
COGEMA -		<u> 100 - 201</u>	7.3	EV	Dss		THER		CONDITION
FILE NAME/ITEM	VERT	بن له مس	PLAT	≓ . 2		DUCER DUAL 🔲 SG	i Ka nose	ANGLE	: .
Xo REF. POINT (I		ed a s	BOINT WAY	Liser-	SCAN	WIDTH.	15		·
PART#/ INDICATION	X START	X STOP	YSTART	YSTOP	AVE. THK.	MIN. THK, R. LIG.	AREA REPORTAS	MAX	.THK.
0-12			· :		.516	,508°		. !	5301
12-24					526	.512"			530"
24.36					-524"				536"
36-48	ļ				.524"	.515"			536"
48 - 60			1-67	•	7525	.504"		1	530"
60.72					524"	.514"			530"
72-84					.5201	,510"		1	5304
84-89.7		<u> </u>			<u>,517"</u>	.501		•	530"
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@ see Attached Letter From J.B. Elder

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LOCA	TION East ta	ak Ca	SYS	EM Ps	:D_4		EXAM		0900	EXAM		JOB #	3-4	
COM	PONENT ID				· · · · · ·	·	EXAMI	HATI	ON SURFACE	•	_ [(CONDIT		
CONF	IGURATION	[0]	- A P				CALIBR	RATE	☐ IO ☐ F D RANGE				TEMP	
				PLO	ate_	<u></u>	6	4	CORRECTION	14"		200	Amb	٥F
CIRC	UMFERENCE/	IOTAL LENGT	H EXAMINEL	8 .0	1.6	7	KEP, L	EVEL	CORRECTION	JN (180	(145, CC	/KK)	<u>ø</u>	08
PROC	EDURE	SULT.	15 - A		F	REV	MATER	RIAL	TYPE CS OTH	. R	Dam.	THE	.509	,,,
FILE	EMA-	24(TI- T	N2 - C	<u>د اد</u>			TRANG	SOLIC	FR					
Y. PE	E POINT /I A	VERT	7. W DI	ا / سد	I (Wa)	<u>E</u> 4	SCAN	DUAL	_ SGL			J ANGLI	42	
i b	elow Ho	ez.we	d 9°	POIN	N'R	564				<u>5_′′</u>			· ·	
	SIZING ME	THOD	A	VGLE	R	FERENCE C	AL. SHEE	T		·	SET	-UP		
	45/60 DEGR AATT	KEE SHEAR	-		=									
	RATT													
	DUAL 0 DEC	GREE			-1	• •						,		
						TION INFO								
IND	METHOD	WELD	DEPTH R. LIG.	MAX AMP	X1	LENGTH	X2	Y1	WIE	TH	Y2		NDICAT	ION
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@ see Attached Letter From J.B. Elder

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	AUT	OMATED U			NESS				
			TA REPO	RT	T ministra		1 2000		er = 31
LOCATION ZODEAST TO	ak Egen	SYSTEM	P5P-4		EXAM S	START 2. 28 15	EXAM	- 1	108# 03~41
COMPONENT ID					EXAMIN	NATION SURF.	ACE		NOM, THICKNESS
660000000000000000000000000000000000000		<u>1- AP</u>		-···		00 🗍 10 [5625"
CONFIGURATION	•	$\mathcal{H}^{\circ r}$	ate		CALIBR	ATED RANGE	1.04		TEMP OF
CIRCUMFERENC	E/TOTAL LENGTI	H EXAMINEO	89.7"		REF. LE	VEL CORREC	TION (TRA	NS, CORP	d D3
PROCEDURE			- R	EV.	MATER	IAL TYPE			CONDITION
Cogema-		<u> </u>	.3		_ □ ss	SC CS O	THER	· 	
FILE NAME/ITEM	VER	r wau/	PLATE	্ৰ	TRANS	DUCER DUAL [] SO	SL 53 098	EG □A	NGLE
X. REF. POINT (L	4)	YAREF F	OINT (Wa)		SCAN	HTDIY			
PART#/	H022. 13	X STOP	Y START	LISCE LYSTOP T	AVE.	LIM TOV	15"	<u> </u>	MAX. THK
INDICATION	VAIVUI	V 010L	ISIANI	13105	THK.	MIN. THK, R. LIG.	REPORTA	BLE	
0-12			:		,585'	.563"			,590"
12-24			<u></u>		<u> ,585"</u>	.567"			1595"
24.36					,585"	15707			.595"
36-46			: واده		· 595"	1573"			.595"
48-60			(c4):	<u> </u>	;585"	.5584			<u> 1515"</u>
60-72			<u> </u>	<u> </u>	<u>຺ຘໟଟʻ</u>	.571"			15951
72-84					585"	. 5394			1595"
84-817			<u> </u>		,58°"	.563			1590"
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@ see Attached Letter From. J.B. Elder

٠.					ONIC A REF	P-SCAN PORT					Riser # 31
LOCA	TION East 72	W FA		SYSTEM 2	SP_C	<u> </u>		START	330 EXA	M END	JOB# 03-41
COMP	ONENT ID	NA FAE			<u> </u>	<u> </u>	EXAM	INATION	SURFACE		CONDITION
COME	IGURATION		101	TO P				OD []	ID PAINTI	ED	TEMP
				PLI	THE	***************************************		2" T() <i>159</i>	,11	AMB
CIRCU	JMFERENCE/T	OTAL LENG	TH EXAM	IINED 6	39 5	5 ''	REF.	LEVEL CC	PRRECTION (T	RANS, C	ORR) & DB
ROC N C	EMA-	SVUT-	TWS	5.F00	f	REV		RIAL TYP S • ⊊2 °CS	E OTHER	NO	m. THX . 5625
ILE N	IAME/ITEM#			a*	- ^-	<u> </u>	TRAN	SDUCER	Disci Di	ייייי ו	X ANGLE 45°
G RE	F. POINT (Lo)	VE	RT	YoREF, POIN	<u> </u>		SCAN	WIDTH			A RIVOLL 15
, p c	HOW HOS		الهاد	Y REF. POIN	24"	Piser-	1		15		T UD
	SIZING ME			ANGLE	RI	FERENCE C	AL. SHE	티		SE	r-UP
	15/60 DEGR	LE SHEAF	`								
	VATT RATT	<u></u>			+						· · · · · · · · · · · · · · · · · · ·
	DUAL O DEC	REE			1-1			_			
	JUNE O DEC	NILL.		11	NDICA	TION INFO	RMAT	ION			
ΔN	METHOD	WELD SIDE	DEP	TH MAX	X1	LENGTH	X2	Y1	WIDTH	Y2	INDICATIO TYPE
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4/00	Δ11Τ	OMATED U	TRASON	JIC THICK	(NESS			<u> </u>
			TA REPO		111200		Β.	Ser # 31
LOCATION		SYSTEM	760	. 1	EXAM :		EXAM END	JOB#
200 EAST	LONK EVE	<u> </u>	PSP	-9	3 120	3 0958	1845	14-50
COMPONENT ID	1	01-AP				VATION SURF		NOM, THICKNESS
CONFIGURATION		70 TO			CALIBE	OD DID C	J PAINTED	750~
COM IGOIGATION	` PLA				CALIBR	MIEU RANGE	A 11	AMB OF
CIRCUMFERENC			105.	G 7	REF. LI	VEL CORREC	TION (TRANS. CO	ORR)
PROCEDURE			1 0	EV		IAL TYPE	······	CONDITION
COGEMA -	- ZVUT- I	<u> 105 - 007</u>	.3			DUCER 0	THER	
	VERT	ware/c	115+17	PLATE4			L 🔂 ODEG [ANGLE
X REF POINT (L	1007 Wold	ď REF P	OINT (Wa) 24 2	. <e-< td=""><td>SCAN</td><td>WIDTH</td><td>15"</td><td></td></e-<>	SCAN	WIDTH	15"	
PART#/	X START	X STOP	YSTART	Y STOP	TÄVE.	MIN. THK,	AREA	MAX, THK.
INDICATION			1		THK.	R. LIG.	REPORTABLE	
0-12	•		ļ		<u>759"</u>	,742"		.765°
12.24					762"	1361		1.770
24.36					1,765,	1756"		1781
3618	ļ	·	<u> </u>		.762"	J 58°		• 270
48-60			ļ		.761"	,757*		.7761
60-72					.761"	.756*		יסרר,
72-84				ļ	740"	,755"		1776"
84.96				ļ	<i>₁</i> ๅรร**	.746"		'926"
96-105.9			<u> </u>		₹355	.246"		.765"
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@ See Attached Letter From I. B Elder

4/00			LTOAS	SNIC	P-SCAN			<u> </u>			
		U	DATA							}	
		•									Riser# 31
LOCATION		SYS	TFM			EXAM	START		EXAM		JOB#
ZOO EAST TA	UK FARI	M	TEM P	SP.	4	dila	02 (1720 SURFAC			03-41
COMPONENT ID		() B	0			EXAM	INATION	SURFAC	E		CONDITION
CONFIGURATION		<u>01-A</u>	· · · · ·	· -		Cális	RATED	D D BANGE	PAINTEL		TEMP
CONTOCKATION		.0	PLA	75		0/12/2	0"	range 70	2.13	2"	DWB of
CIRCUMFERENCE/	TOTAL LENGT	H EXAMINE	D 1	<u>0</u> 4	יי די	REF.	LEVEL C	ORRECTI	ON (TR	ANS, CO	DB
K-EMA-	-Tuv2	T.4\S		F	REV	[] ss	RIAL TY	S OTH	ER	note	<u>. 7</u> 44 .756"
FILE NAME/ITEM#		er, w		DI 60	-vs U						ANGLE 45°
Xo REF, POINT (Lo)		Ye.	REF POINT	(Wo)	<u> </u>	SCAN	WIDTH				<u> </u>
"below Ho	<u>ez. Wel</u>	<u>d 19</u>	04 21	in 5	ISEr			(<u>5″</u>		
SIZING ME	ETHOD	A	NGLE	RI	FERENCE C	AL. SHE	ET	_		SET	-UP
1 45/60 DEGF	REE SHEAR					·					
2 AATT				1						<u></u> .	
3 RATT							\Box				
4 DUAL 0 DE	GREE	<u> </u>			4 -,						
					TION INFO		,	1		1 1/2	LUIDIOATION
IND METHOD	WELD SIDE	DEPTH R. LIG.	MAX AMP	X1	LENGTH	X2	Y1	VVII	т	Y2	INDICATION TYPE
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@ See Attached Letter From J.B. Elder

4100	AUT	OMATED UI	TA REPO	PT TG	KNESS			D. 40 # 5.
LOCATION		SYSTEM	PSP-		EXAMS	TART	S EXAMEN	D Ser # 31
200 EAST T	ANK FARM	1	1225-	y	יס וויי	2 13.20	1322 ACE	03-4)
COMPONENT ID		01-AP)	•	EXAMIN	ATION SOM	ACE	NOM THICKNESS
CONFIGURATION		70) CALIBR	OO □ ID [ATED RANGS		
	PLA	STL				3" To	1.0"	Amb of
CIRCUMFERENC	E/TOTAL LENGT	H EXAMINED	20.9				CTION (TRANS	Ø D8
PROCEDURE COGEMH -: FILE NAME/ITEM	SYUT IN	5-007	S. RE	1			THER	CONDITION
LICE MANGENTENIA	้	i wall	PLATS				EL MODEG	ANGLE
X REF. POINT (L	PU 530H	d Ger	OINT (Wa)	21ser	SCAN V	T	5";	
-PART#/ INDICATION	X START	X STOP	YSTART	Y STOP .	AVE. THK.	MIN. THK. R. LIG	AREA REPORTASI	
0-12			<u> </u>		.875"	.365		,900"
12-20,9	<u> </u>				.375"	.860		19000
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			U		SONIC A REF	P-SCAN						
				D A1.							RISE	~ * 31
LOCAT	EAST TAK	ik Farn	n SYS	TEM 7	SP-	4	EX	AM STAF	0 8 65	EXAM END	JOB#	3-4
COMP	ONENT ID					····	Ēλ	ØMINATI	ON SURFACE	Ε	CONDITIO	אל
CONFI	GURATION	<u>_</u>	10 TO	77. 1			CA	LIBRATE	DRANGE		<u>' </u>	TEMP
CIRCU	MFERENCE/	OTAL LENGT	H EXAMINE	D	376		- RE	F. LEVEL	TO 2.	S''	CORR)	AMB OF
PROC	DURE				20,9	REV		TCOLA	LYOF	·		OB DB
		· · · · · · · · · · · · · · · · · · ·	· · · · · · · · · · · · · · · · · · ·			· · · · · · · · · · · · · · · · · · ·		SS 🔏	CS OTH	ER <u>NO</u>	m.TH	.875"
	AME/ITEM#	V Exc	400.7	ue/ F	>LR7	E 5	TR	RANSDUC DUAI	er . 🔊 SGL	ODEG	ANGLE	450
X, REI	POINT (Lo)	ez wek	1 or	REE POIN	T (Wa)	CO-	SC	AN WIDT	LI	5"		
, 10 E	SIZING ME	THOD	A	NGLE	R	FERENCE C	AL. SI	HEET	`		T-UP	
		EE SHEAR										
	ATT											
	OUAL O DEC	GREE	; 			-						
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DNI	METHOD	WELD SIDE	DEPTH R. LIG.	MAX AMP	X1	LENGTH	X2	Y1	WIE	TH Y2		IDICATION YPE
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@ See Attached Letter From J.B. Elder

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FILE NAME/ITEM	#	Juan!		ATE /	TRANS	DUCER DUAL [] SO		с Па	NGI F	
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Att. 3-13

4/00		U		ONIC A REF	P-SCAN PORT					13	Ciser#:	S 1
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1 45/60 DEGR	EE SHEAR											<u>·</u>
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@ See Attached Letter From I. B Elder

4/00	AUT	OMATED UL	TRASON	IIC THICK	NESS			•
			TA REPO	RT			<u> </u>	(Ser # 31
LOCATION 200 EAST TO	auk Faem	SYSTEM	1-92C		EXAM	SIART 12 072	S ISIS	JOB# 03-41
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CONFIGURATION	V	10		·	CALIB	ATED PANGE		TEMP
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4/00			ι		ONIC A REF	P-SCAN PORT				·		Ser # 3i
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@ See Attached Letter From J. B Elder

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COMP	PONENT ID				<u> </u>	1	EXAM	HIATE	ON SURFACI	Ξ.	100	ONDITION
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4	DUAL 0 DEC	SREE			177	7101411170	F34.4.37		l <u></u>			
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@ See Attached Letter From J. B. Elder

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LOCATION		DA SYSTEM	TA REPO	RT	Fyure	¥15=	Tevner	15186-4 31
200EAST	TANK FAR	M 31315m	PSP-	4	EXAMS		EXAME 1500	03-11
COMPONENT ID		I-AP	········		EXAMIN	NATION SURF	ACE D PAINTED	NOM THICKNESS
CONFIGURATION	PLAT	É TO			CALIBR	ATED RANGE	1.0"	TEMP OF
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24-36					585"			.400"
36-48					·590°			,6004
48-60			1.42	٠ .	590"			16007
60.72					592"	1574h		, 600
72-84	•		<u> </u>		590"	,5697		,600'
84-886					,58 <i>5</i> ^	1559"		5957
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			101-					≰ OĐ	ON SURFAC	e Painted	CONDITION
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@ See Attached Letter From J.B. Elder

LOCATION SYSTEM SOC EAST TANK FACE COMPONENTIO 101-AP COMPONENTIO 101-AP COMPONENTIO 101-AP COMPONENTIO 101-AP COMPONENTIO CONFIGURATION PLATE CONFIGURATION PROCEDURE CONFIGURATION VERT VAMEND CONFIGURATION VERT VAMEND CONFIGURATION CALIBRATE PROSECTION (TRANS CORR) DB CONFIGURATION CONFIGURATION CALIBRATE PROSECTION (TRANS CORR) CAL	4/00	AUT	OMATED UI	TRASOI		NESS		D.,	se- # 31
COMPRISION TO TO SUPPOSE STATE TO CALIBRATION SUPPOSE STATE TO CALIBRATE PRANTED TO CALIBRATE	LOCATION 200 EAST	TANK FARI	SYSTEM			EXAMS	START	EXAMEND	JO8#
CONFIGURATION PLATE TO CALBRATE RANGE 3" TO 10" Anh of CRICUMFERENCE/TOTAL LENGTH EXAMINED 104.6" REF. LEVEL CORRECTION (TRANS. CORR) PROCEDURA—SWUT—INS—007.3 REV ANALYSE CONSTITUTION FILE NAMEDITEMS VERY WALL 10 10/PLATE 1 TRANSOUCER MOUSE SELVEN TO 10 10 10 10 10 10 10 10 10 10 10 10 10	COMPONENT ID				-	EXAMIN	NATION SURF	ACE	
CIRCUMFERENCETOTAL LENGTH EXAMINED OUT, 6" REF LEVEL CORRECTION (TRANS.CORR) DB	CONFIGURATION	٧ .	70			CALIER	ATED RANGE		1 TEMP
PROCEDURE SUIT-INS-001.3 REV MATERIAL TYPE OS MICE CENTRION TOSEMINA SUIT-INS-001.3 PART FILE NAME PROVIDED SO OTHER FRE NAME PROVIDED SO OTHER TRANSDUCER TRANSCUCER TRANSDUCER TRANSDUCER TRANSCUCER TRANSDUCER TRA	CIRCUMFERENC			104	<u></u>	RSF, LE	EVEL CORREC	TION (TRANS. CO	RR)
FREE PAINT (La)	PROCEDURE	CUIT TA	10 000						
Yellow Hole week Yellow Hole Yellow Ye	FILE NAME/ITEM	#	•			TRANS	DUCER		
PART # X STOP Y START Y STOP AVE. THK. R. LIG. REPORTABLE AVE. THK. R. LIG. REPORTABLE AVE. THK. R. LIG. REPORTABLE AVE. THK. R. LIG. REPORTABLE AVE. THK. R. LIG. REPORTABLE AVE. TO A TO A TO A TO A TO A TO A TO A TO	X ₃ REF. POINT (L		1 11	OINT (Wa)	"Fran CL	SCAN V	OUAL SO WIDTH		ANGLE
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	PScan		2. L	ever 777	Date 1127	लक्ट ।	Level	Date	_ ^{or}

(1) See Attached Letter From J. B Elder

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4/00		1.1	LTRASO	NIC	P-SCAN						1			
		· ~	DATA											
		- *			•						1	Ris	er *	31
LOCATION		SYS	PS	$\overline{\Delta}$			EXAM	STAR	T	EXAM	END	JOB		
200 EAST T	ank fa	em	<i>P8</i>	K	4		11/13	02	T 07/0 DN SURFAC	/7:	٥)3~L	11
COMPONENT ID							EXAM	NA HO	DN SURFACI	E Paimtei	` \	CONDIT	ION	÷
CONFIGURATION		101-1	3E	•			CALIS	VATE	DRANGE				TEM	
	·		PLA	371	<u>: </u>			6 "	TO	2.12			AN	1B 01
CIRCUMFERENCE	TOTAL LENG	I H EXAMINE	10	4 . c	'n		REF. L	EVEL	CORRECTION	ON (TR	ANS. C	ORR)	Q	DB
PROCEDURE					REV.	-	MATER	RIAL T	YPE		_,			
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FILE NAME/ITEM#	VI IZ O	- 1	1 12 -	J	Over		TRANS	DUC	ER Б∦SGL	ET AN	EC	ECLANICH		50
Xa REE POINT (LA)	V E 10	7, WP	REE POINT IV	10 T	1" From C	_	SCAN	VIITI	u		20	D) ANGL	<u> </u>	<u>. </u>
XOREF POINT (LO)	ez wek	1 6	PASS 7	<u>،</u> و	PLATEY 1" From CL of 2 M AN	3			<u> </u>	s''				
SIZING M	ETHOD	_ Al	NGLE	R	FERENCE C	AL	SHE	:T			SE	T-UP		
1 45/60 DEGI	REE SHEAF			·										
2 AATT						_								
3 RATT		<u> </u>		35 145]						·
4 DUAL 0 DE	GREE				• •									
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IND METHOD	SIDE	DEPTH R. LIG,	MAX X AMP	(1	LENGTH)	(2	Y1	WIE	тн	Y2		NDIC. TYPE	ATION
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4/00	AUT	OMATED U	LTRASON		KNESS			<u> </u>	
LOCATION 200 EAST	TANK FAR	SYSTEM			EXAM	2 /25	EXAME	1	
COMPONENT ID	` I				EXAMII	VATION SURF	ACE	NO.L.	HICKNESS
CONFIGURATION		01-A			CALIBR	ATED RANG	=	I TE	MP
CIRCUMFERENC	PLAT E/TOTAL LENGT				REF 11	3" 70	CTION (TRAN	IS CORRI	nb of
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COGEMA-	SVUT-3	ENS-00	ภ. ร	EV 1		MALTYPE	THER	. 00	NOITION
FILE NAME/ITEN	1 #	WALL/21			TRANS	DUCER			
X ₂ REF. POINT (- V 라스 I · · 나),	eld of let	POINT (Wa)	" Frem C	L SCAN	MIDTH		G ANGLE	
PART#/	HODE W	eld of 12	Y START	LOF 200P	ACS AVE.	MIN. THK,	I AREA	MAX. TH	<u> </u>
INDICATION	7 917131	X 510F	1 BIAAT	1310	THK.	R. LIG.	REPORTAS		n
0-12					.876"	.871"		.88	
12-21.2		<u> </u>	<u> </u>		.875	.866"		. 9 8	ź.,
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4/00			L			P-SCAN		_	· · · · · · ·				
LOCA	TION EAST TA	NY EAR	SYS	тем 🚡	God			VI STAF		EXAM EN	10 JC	Ser#31	
COM	PONENT ID	ON TAC		-AP			EXA	Miliati (1 oo	ON SURFACE	: AINTED	CON	O3-41 DITION	
COM	IGURATION		Oĭ		TA.	<u>.</u>	CALI	BRATE	D RANGE	2.5"		TEMP AMB	c F
CIRC	JMFERENCE/	TOTAL LENGT	'H EXAMINE	D i	21.1"		REF.	LEVE	LCORRECTIO	N (TRANS	S. CORR)	DB	
PROS	EMA -	SWIT_	TING_			REV	MAT	ERIAL	TYPE	: D	410 m	T#X .975	
CITC	TARACATERAC					- · · · · ·	TOAL	VSDITO	:FR				
X ₀ ,RE	F. POINT (Lp)	V 753	ZT USI	REF. POIN	NO T (Wo) 1	PLATE 5	SCAI	J DUAI	ri i		LAT AN	GLE <u>45°</u>	_
1 pt	SIZING ME	<u>የደ૨. ሀን</u> ቂ THOD	10 10-1	NGLE	S To	EFERENCE C	AL SHE	FT		5"	SET-UP		
1 '	45/60 DEGR				<u> </u>	<u> </u>	, IL, UIII				1-01		•
	AATT												
	RATT DUAL 0 DEC	POEE											
	JOAL O DEC	SKCE			NDICA	TION INFO	RMAT	IÓN	<u> </u>				-
IND	METHOD	WELD SIDE	DEPTH R. LIG.	MAX AMP	X1	LENGTH	X2	Y1	WID	TH Y	'2	INDICATION TYPE	1
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Exa	niner	1.60	An	alyst <i>Volle</i>	_ 1\	n.		view h	ver		1	Page	
Leve	SCAN LA	te [1][3]	Le	vei 712	Date	1/26/03	Le		Date_	· · · ·	_	of	

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4/00								
	TUA	OMATED U			KNESS	•		.1
. 0017/01			TA REPO		T ever		<u> </u>	Ser # 31
LOCATION PAST	TAOK FARI	U SARIEW	PSP-	4.	EXAM:	START 02 080	EXAMEND 1350	JOS# 63-41
COMPONENT IC				1	EXAMI	VATION SURFA	,CE	NOM THICKNE
CONFIGURATIO	51	101-A	<u> </u>		CALLES	OD [] IO [ATED FANGS] PAINTED	15MP
		t	KNUCK	سع		3" TO	1.0"	Amb
	CE/FOTAL LENGTH		104.7		RSF, LE	EVEL CORREC	TION (TRANS. COF	 D8
PROSEDIMA.	I-TUVZ-	NS-00	7.3 R	ΕΥ.		IAL TYPE	เกะซ	CONTICHO
FILE NAME/ITEN	12				TRANS	DUCER		·
Y DEE POINT	1 of Storted	BW/KN	POINT MA	· · · · · -	SCAN'I	MOTIL	L 🔯 ODEG 🗀	ANGLE
Borth A.	LO Started	2/1-1	selow H	ORZ WE	eld	UDIN	2. ዛ" {	
PART#/ NDICATION	X START	X STOP	YSTART	YSTOP	AVE. THX.	MIN. THK.		MAX. THK.
0-12		<u>-</u>	 	 	1937"	R.LIG. .889"	REPORTABLE	. 950"
12-24		· · ·	1		935"	907"		945
24-36					935"	912"	·	, 945"
36-48					9.35	.406		1945"
48-60				1	1934	891"		945"
60-72					,435"	.871"	,	,945"
2-84					.9351	1875"		1945"
4-96			<u> </u>		1,939"	.891"	· .	1945"
6-104.7		. <u>. </u>		<u> </u>	938"	.905"		945"
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4/00					TAC	A REI	P-SCAN			-				R	ser#	31
2001	TION EAST TO	ANK FAR	m	SYS	TEM PS	P-4			EXAM ST.	AR 2	1405	EXAM 22	CN3 N	10		
COM	PONENT ID			- A					EXAMINA	TiC	IN SURFA	CE		COND	ITION	
CON	IGURATION,		01-	10	<u></u> اد ادا	uck	. 1 14	<u>.</u>	CALIBUA	iei	7. To	7	<u>السسا</u> الامع		TEMP	ઉ લ
CIRCI	UMFERENCE/	TOTAL LENGT	H EXA	MINE	`	4.9		_	REF. LEV	ĒĹ	CORRECT	10N (TF	ans. C	ORR)	∑ _1 <u>1≥w</u> 1	
PROX	EDURE		مام	 .			REV		MATERIA	<u>.</u> Ť	Y ²¹ .				THY 9	DB
FRET	EMA - S	<u> </u>	N3	<u>-0</u>	<u>07.3</u>				☐ SS TRANSDU	IC:	FR					
X ₃ RE	F. POINT (Lo)S	Y- L Starfed(g Jen	7 / F	KNU.	CKL	FEEE Weld	_	SCAN WIT	AL DTI	⊼ 5GL H			ANC	3.E_45°	,
Nort	SIZING ME	1400		2	." bel VGLE	ow A	bez weld EFERENCE C	i A	CUEET	_		12'		T-UP		
1 4	45/60 DEGR		-		VOLE		EPERCINCE C	///	SHEET	1			OE.	1-01		
2	TTAA							_								
	RATT DUAL 0 DEC	20EE	-							{						
*	DOAL O DEC	JALL	Ш.		11	1DIC	ATION INFO	R	MATIO	<u>٦</u>						
ND N	METHOD	WELD SIDE	DEP R. L		MAX AMP	X1	LENGTH		X2 Y	1	W	ПТН	Y2		INDICA TYPE	TION
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(b) See Attached Letter From In B Elder

4/00	TUA		ULTRASONIO ATA REPOR		IESS			C15er#31
LOCATION		SYSTEL			I EXAMS	START	I EXAMEND	103#
200 EAST	Tauk Far	m	, beb-	.	12/12/	3EPO SO	1100	03-41
COMPONENT ID	17	01-AF	>	-		NATION SURFA		NOM THICKNESS
CONFIGURATION		_	KNUCKL	£	I CALIBR	ATED RANGE	•••	TEMP OF
CIRCUMFERENC	E/TOTAL LENGTI	H EXAMINED	114.5		F.SF. LE	EVEL CORREC	TION (TRANS. C	ORR) _ D8
PROCEDURE	SHIT TH	5 - Acz :	REY			NAL TYPE	uso	CONDITION
FILE NAME/ITEM	7				TRANS	DUCER .		
Y-ARM/KNUCICLE A SIDUAL SGL BODEG A								
North Airl		2"	peron Hoes Peron Hoes	L weld	SCAN	HTOIN	11.5"	
PART#/ INDICATION	X START	X STOP	YSTART	STOP /	YE. HK.	MIN, THK, R. LIG.	AREA REPORTABLE	MAX. THK.
0-12			- :		945"	1895"		955"
12.24					945"	.897"		9 50"
24-36					9401			1950"
36-48	· · · · · · · · · · · · · · · · · · ·				936"			.945"
48-60					<u> 432"</u>			1940"
60-72					935^			1945'
72-84					932"	·866"		,945"
84-96					930"			1940"
96-108					936"	.871"	· · · · · · · · · · · · · · · · · · ·	1940"
108-114.5			_		930"	.877"		.940"
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SCAN 24 7	TSUR	400	ATPOC	-250G	OF.	VIZUX.	MET()	NORTH NE
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Att. 3-27

4/00	DATA	NIC P-SCAN REPORT		•	Q15er * 31
LOCATION 200 GAST TANK Form	SYSTEM PS	D U	EXAM STAR	EXAME 135	ND JOB#
COMPONENT IO		,	EXAMMATIO	ON SURFACE	CONDITION
CONFIGURATION	-AP		CALIBRATEI	☐ ID ☐ PAINTED	TEMP
	Lengu	CKLIE		12 cm 2 65	5/1 N-012 0F
CIRCUMFERENCE/TOTAL LENGTH FX	AMINED	.8*	REF. LEVEL	CORRECTION (TRAN	vs.corr) &dbb
PROCEDURE COGEMA -SYUT - INS		REV	MATERIAL T	YPE CS OTHER	NOM. THE ,937"
FILE NAME/ITEM#			TRANSDLO	FR .	
Xo REF. POINT (Lo) Started Q	/ KNUCKLES	No)	SCAN WIDT	H	G MANGLE 45°
XOREF POINT (LO) Started &	2" below	o Horz Web	U	12"	
SIZING METHOD	ANGLE	REFERENCE CA	AL. SHEET		SET-UP
1 45/60 DEGREE SHEAR 2 AATT					
3 RATT					
4 DUAL 0 DEGREE					
		ICATION INFO	RMATION		
	PTH MAX >	(1 LENGTH	X2 Y1	WIDTH	Y2 INDICATION TYPE
					
				- - - - - - - - 	
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REMARKS NO CRACK I EX Scan Started @	· ·		nt wel	Hrou ,b	of zu" Riser
Examiner	Analyst		Review	er .	Page
Level 10 Date 12/18/02	Level VA	ate 1/21/03	Level_	Date	of
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4/00	AUT	Ε	ULTRASON DATA REPO	рт	(NESS .			P1	ser # 31	,	
LOCATION 200 EAST	TOAL EAD	SYSTE	M 72P-U		EXAMS	TART 02 080	EXAM		14-EQ		
COMPONENT IO		01-AF			EXAMI	NATION SURF	ACE		NOM, THICKNES	S	
CONFIGURATION		TO			CALISS	ATED RANGS	-		TEMP		
CIRCUMFERENC	ENOTAL LENGT	H EXAMINED	KNACKT	<u> </u>	ESE I	REF. LEVEL CORRECTION (TRANS. CORR)					
·			16.1"						P D3		
COG-EMA	-SVUT-I	NS-00	7.3	\ \	□ ss		THER		CONDITION		
FILE NAME/TEM	94-V	MLKLE TE	TRANS	DUCER DUAL □ SC	ei £ a tena	in Eile	NGIF				
X REF. POINT (.s) Started (🛂 l Yore	F. POINT (N/s)		SCAN	MOTH					
North Air	LINE.	X STOP	below Ho	LS Merc	AVE.	MIN. THK	Z.Z"		MAX. THK.		
INDICATION					THK.	R. LIG.	REPORTA				
0-12			:		950"	,906"			1960"		
12-16,1					<u> </u>	1916"			1965"		
						<u> </u>					
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STARTE	D D 30	ATV) & T	OB OF	SECON	D VIED	T 1251	7	FRT	WELD		
SOUTH	oF 24"	PESCY			· · · · · · · · · · · · · · · · · · ·						
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@ see Attached Letter From I. B Elder

4/00				DATA	A REF								و,	3e r ≠	31_
LOCA	Tion East ta	NK FARM	SYS	TEM PS	ξ Ω_ ι	1		EXAM ST.	RT	Ula B	EXAM	1 END	I JOE)# 0 3-4 /	•
COM	ONENT ID				<u> </u>	3	-	EXAMINA	TIO	N SORFAC	Œ	ı	COND		
0000	IGURATION		<u>01-10</u>	76			_	CALIBRAT) [10 🗆	PAINTE	D		-1-22785	·
CUNF	IGURATION		10		u 0/21	13	ļ	CALIBRAT	LU }	RAN(*	2.6	5"		TEMP	R of
		TOTAL LENGTH		0	12,4			REF. LEV	ÉL C	GRRECT	ION (TR	ANS. C	ORR)	Ø	D8
COGEMA - SUUT-INS - 007.3 MATERIAL TYPE SS KICS OTHER NOM									n T	4x .93	57"				
FILE NAME ATEM# Y- ARW / KNUCLUE B DUAL ED SGL DOEG ED ANGLE 45° North Artine 2" below Holz weld SIZING METHOD ANGLE REFERENCE CAL SHEET SET-UP															
X ₀ RE	F. POINT (Lo)	Started 6	5 1	REF POINT	(Wo)	المامان حمد	I	SCAN WIL	ΉŤ		12"	,	•		
NOT	SIZING ME	THOD	T A	NGLE	R	FERENCE C	AI.	SHFFT	7				Γ-UP		
	- 10211 TO 1112	EE SHEAR	 						+				<u> </u>	· · · · · · ·	
	AATT		1				_		+						-
	RATT								1						
4 [DUAL 0 DEC	SREE			1.35	٠									
						TION INFO	_		1						
IND	METHOD	WELD SIDE	DEPTH R. LIG.	MAX AMP	X1	LENGTH	\ \	(2 Y	1	Wi	DTH	Y2		INDICA TYPE	TION
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Exa	miner		An	alyst	ط ج	m		Revie	we	۲	····		P	age	
Leve	Da Da	le <u>1.4/6/0</u>	Le	vel A	Date	1/24/03		Level	-	Date	ē		-	(of

@ See Attached Letter From J. B. Elder

4/00	AUT		_DAT	TRASON	NIC THIC	KNI						٤31
LOCATION 200	TANK FROM	٠ ا	SYSTEM	2594			EXAM:	START 103 OS (S	MAXE	END	108#	3-41
COMPONENTIC)						EXAMI	NATION SURF	ACE		NO	M. THICKNESS
CONFIGURATIO	uk!	101	TO TO				CALIGO	OD DID (PAINTED	1	لهسلب	<u> ዓንን "</u> Τέмр
CONTIGORATIO	KNU	(12)	. —				CALIBR	ST TO	1.0			AMB OF
CIRCUMFEREN	CE/TOTAL LENGT	H EXAM	INED	7.5"			REF. LI	EVEL CORREC	TION (TRA	NS. CO	RR)	C₃ DB
PROCEDURE	A - SVUT	- Z o	ىن- دى ىن- دى	7.3 R	EV /		MATER SS	MALTYPE ZOS C	THER			CONDITION
FILE NAME/ITEM	7- De		540T				TRANS	DUCER DUAL [] SO	SL KODI		ANGLE	
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ND SEE ATTACHED LETTER FROM J. B. ELDER

4/00	AUT	OMATED U	TA REPO					RISE			
LOCATION 200 ENST T COMPONENT ID			259.4		EXAM	NATION SURF	ACE	0	VOM, THICKN	ESS	
CONFIGURATION	KNUC			· · · · ·	CALIBRATED RANGE TEMP						
CIRCUMFERENC PROCEDURE	E/TOTAL LENGT	H EXAMINED	รก"		REF. LEVEL CORRECTION (TRANS. CORR) DB MATERIAL TYPE CONDITION						
	.	- INS-00	27.3	1	☐ SS						
XO REF. POINT (LO) N A YO REF. POINT (WO) SCAN WIDTH											
PART#/ INDICATION	X START	X STOP	Y START	Y STOP	AVE. THK.	Min. THK, R. Lig.	AREA REPORTAB	3LE	AX. THK.		
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LOCATION	SYSTEM PSP		·].	EXAM.S	TART	EXAM	END	JOB#	
COMPONENT ID	137	<u> </u>			ATION SURFA		10	NOM THIC	
101-			1	2 3 (00 🗆 ID 🖂	PAINTED		NOW. ITHO	
CONFIGURATION RUCKLE				CALIBRATED RANGE TEMP					o _F
CIRCUMFERENCE/TOTAL LENGTH EX	AMINED 7.	2 ''		REF. LE	VEL CORRECT	ION (TRA	NS. CO	RR)	DB
PROCEDURE		REV		MATER	IAL TYPE			COND	
FILE NAME/ITEM#						HER			
Y-ARI	n I SLOT B			TRANS	DUCER DUAL ☐ SGL	DR 008	G 🗆	ANGLE	
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LOCATION		SYSTEM			EXAM	START	EXAM END	JOB# C/3-4)	
200 EAST	TONK FARM	·	25P-4				5 1035		
COMPONENT ID	````\	1- AP				NATION SURF		NOM THICKNESS	
CONFIGURATION		TO		 	CALIBO	OD DID (PAINTED	TEMP	
COMPRON	" لابه بيحيكا				CALIBR	2 4	. 🔥		
CIRCUMFERENC	E/TOTAL LENGTH	EXAMINED	7,1	n N	REF. L	EVEL CORREC	CTION (TRANS. C	ORR) & DB	
PROCEDURE	-C.11.15" 5".	5-002	R	EV		RIAL TYPE	THER_	CONDITION	
FILE NAME/ITEM		SLOT 1			TRANS	DUÇER		T ANGLE	
Y - PL M SLOT D M DUAL SGL ODEG									
PART#/ INDICATION	X START	X STOP	Y START	Y STOP	AVE. THK,	MIN. THK, R. LIG.	AREA REPORTABLE	MAX. THK.	
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	<u></u>		ATA REPO	KI .							
LOCATION	-	SYSTEM	P5P-4		EXAM	START	EXAM END	JOB #	3-41		
COMPONENT ID	Tank far	<u>^</u>	P 28-4		- 10 1 3 I	NATION SURF	4 1338	INC	OM, THICKNESS		
COMPONENTIO	10	1-40							+ 50°		
CONFIGURATION	1 /	TO	-		CALISE	CALIBRATED RANGE					
	PLAT		PLATE		1	3" <u>70 /</u> .	0"	· · · ·	AMB of		
	E/TOTAL LENGTH	REXAMINED	90,3		REF, LEVEL CORRECTION (TRANS. CORR) & DB						
PROCEDURE COGEMA	SVUT. E	~5~ 007.	R	1		RIAL TYPE (R)CS O	THER		CONDITION		
FILE NAME/ITEM	#		- 4		DUCER						
Xo REF. POINT (L	VEKT. C	ی ډېري (د) 60 7L POINT (Wo)	ATE			SL 🔛 ODEG	ANGL			
5782780 1"	-0) Bilida Horz. (ישיים ו	LOFVan	r. W (LL D		9	,8"				
PART#/ INDICATION	X START	X STOP		Y STOP	AVE. THK.	MIN. THK, R. LIG.	AREA REPORTABLE		CTHK.		
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12-24					.515"	,506°			\$30*		
24-36					515	1204.			530"		
36.48					·515"	15(6"			536*		
48-60					.518*	.504"			530"		
40-72					,517"	.500"			530"		
72-84				f	15/5"				530 4		
84-90.3					.515	.501"			530'		
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4/00		U	LTRASC DATA		P-SCAN PORT					,	Riser 31	
LOCATION 2005AST 7	DN K FD	SYS	PS	P	<u> </u>	EXAM 3/13	START	08:20	EXAM 13	LEND 42	J08#	
COMPONENT ID		21-A				EXAM	EXAMINATION SURFACE CONDITION OO D ID PAINTED					
CONFIGURATION	PLA	TO		· E		CALI	BRATEC	RANGE			TEMP AMB of	
CIRCUMFERENCE/T				1.8	3 1 .	REF.	LEVEL	CORRECT	ION (TR	ANS. CO		
PROCEDURE COGEMO	-5VUT	·*~.	ONT 7	F	REV	MÀTI I S	RIAL T	YPE CS OTH	ER.	TIK.	.MAT: 1500"	
FILE NAME/ITEM#	1507. L	V EI V	10/60	PL	ATE.2			-			ANGLE 600	
VOLCE LOUGH [FO]		1.10	VEL LOUNT	(410)	, , , , ,	SCA	WIDTH	9	4"	1		
SIZING ME			<u>op wh</u>		EFERENCE C	AL. SHE	ET (<u>'</u>	SET-	UP 9U	
1 45/60 DEGR				1								
2 AATT		_		 								
3 RATT 4 DUAL 0 DEG	PEE			+-								
- DUAL U DEC	חכב		IN	DICA	TION INFO	RMAT	ION					
IND METHOD	WELD SIDE	DEPTH R. LIG.		X1	LENGTH	X2	Y1	Wil	DTH	Y2	INDICATION TYPE	
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4/00	TUA	OMATED UI	LTRASON TA REPO		KNESS			RZ	sec 31
LOCATION		SYSTEM	0604	-	EXAM S	START	EXAME	END JO	9 #
200 EAST	<u>TANL FAC</u>	<u> </u>	<u> PSP-4</u>		119/03	083	<u>5 135</u>	مار	03-41
COMPONENT ID	- 10	اد-AP			12	VATION SURF	PAINTED		NONL THICKNESS
CONFIGURATION	PLA	70 मिट १	PLAYE		CALIBR	ATED RANGE			TEMP OF
CIRCUMFERENC			୧୫,୩		REF. LE	VEL CORREC	KAT) NOITS	NS. CORR)	6 √ DB
PROCEDURE COLEM	5 KW15-		R		MATER	IAL TYPE		•	CONDITION
FILE NAME/TEM	3	it, well			TRANS	DUCER	THER		
Xo REF. POINT (L		Yo REF. P	ONTAKE	162	SCAN V	DUAL DISC	SL 🔀 00E	G □AN	GLE
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PART#/ INDICATION	X START	X STOP	YSTART	Y STOP	AVE. THK.	MIN. THK, R. LIG.	AREA REPORTAS		IAX THK
0-12					.580"	,562"			. 590"
12-24	·				,5837	.562°		1	590"
24-36					,594	568"			590"
36.48					.585"	1576"			. 596"
48-60		·				565"			.590"
60.72						-570"	· .		1595"
72-84			<u> </u>		, 585°	.563"			<u> </u>
84-889			ļ		1580	,564-			. 598"
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LOCAT	ION	NK FOR		SYST	TEM De	9-4	/	EXAN	STAR	ा ७ ६५5	EXAM		JOB# 03-41
	ONENT ID					, ,		EXAN	IINATK	ON SURFAC	E	CC	ONDITION
CONE	GURATION		01	- <u>A</u>	<u> </u>		· · · · · · · · · · · · · · · · · · ·	CA116	OD	D RANGE	PAINTEC	<u> </u>	TEMP
ł		PLAT	S		PLA	TE	<u></u>				3,0	**	عمدها
		OTAL LENGT			,	87, 2	. ^		LEVEL	CORRECT	ION (TR/	NS. COR	R) SQ DB
PROC	EDURE EMIL CI	n I-Thy	· -	^^	7 2	F	REV I		RIALT	YPE CS OTH	(ED	7	AK562"
FILE N	AME/ITEM#							TOAL	I O I LO PI	20			
V BE	F BOUT # 1	VERT	<u>. ل</u>	75	D/P	LAT	<u> </u>		DUAL	SGL	<u>□</u> •00	EG BY	ANGLE 600
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1 4	5/60 DEGR	EE SHEAR											
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3 F	WIT.												
4 C	DUAL 0 DEC	REE	i_					·····				<u> </u>	
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IÑD	METHOD	WELD SIDE		TH JG.	MAX AMP	X1	LENGTH	X2	Y1	Wii	DTH	Y2	INDICATION TYPE
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	Tank Faem	SYSTEM	·	EXAMS	TART OP 15	EXAMEN 3037	
COMPONENT	D 101	AP		EXAMIN	ARUS MOITAL	A.CE	NOM, THICKNES
CONFIGURATIO	PLATE	TO PLAT	/- L	CALIER	ATED RANGS		TEMP AMB
CIRCUMFEREN	CE/TOTAL LENGTH EX	AMBREO	,40	. P.S.F. LE	YEL CORREC	CTION (TRANS	S. CORR) & DB
PROCEDURE	•		REV /	MATER	IAL_TYPE		CONDITION
FILE NAMERITE	A - SVUT-IN		<u> </u>	TOTALC	DUCER O	THER	
VIERT XX REF. POINT	WELO /	YOREF. POINT (Y)	d PLATEY	A SCANY	OUAL SO	SL 🗵 00EG	ANGLE
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LOCA	tion Erst Try	NV FAR	2	SYST	EM D<	9-4	i ·	EXA	START	40 EXAM	JENN J	08# 03-4)
COMF	ONENT ID			04				EXAN	INATION SU	JRFACE	COV	IDITION
CONF	IGURATION	12	21-	AF TO				CALIE	RATED RA	D PAINTE	<u>, </u>	TEMP
CIRCI	JMFERENCE/I	TLATI		LUNCO	PLA)		~ - /			RECTION (TR		AMB OF
		OTAL LENGT	11 52	WAIII AS'T	· .		,37/777			AZCION (III		
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X ₀ RE	F. POINT (Lo)	<u>eei, w</u>	<u></u>	Yof	EF. POIN'	T (Wo)		SCAN	WIDTH	10,50	1	10015
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4 1	DUAL 0 DEC	BREE				<u>IDICA</u>	TION INFO	ፕልክናር	ION			
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	ULTRASONIC THICH	KNESS			
	DATA REPORT				Isen 31
LOCATION SYSTE	M PSB4	EXAMS	iart <u>5 063</u> ,	EXAMEND	108#
COMPONENTID 101-AP		EXAMIN	IATION SURF	ACE	NOM THICKNESS
CONFIGURATION TO	PLATIC	CALIBR	ATEO RANGE		TEMP AMB OF
CIRCUMFERENCE/TOTAL LENGTH EXAMINED	15:1"	REF. LE	VEL CORREC	CTION (TRANS. C	CORR) & DB
PROCEDURE COGEMA - SVUT-ZNS - C	REV ,		IAL TYPE	TUEO .	CONDITION
FILE NAME/ITEME		TRANSI	DUCER		
X ₂ REF. POINT (La) Y ₂ RE	F. POINT (Wa)	SCAN V	VIDTU	GL 🛛 ODEG	ANGLE
1" BULLOW HORZ, WULLD de	OF VERE WILL		$\sim -I$	0,9";	1
PART#/ X START X STOP INDICATION	Y START Y STOP	AVE. THK.	MIN, THX, R. LIG.	AREA REPORTABLE	MAX. THK.
0-12	<u> </u>	.875^			1895"
12-15,1		,87Z"	1852*		, 9804
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SUMMARY					
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REMARKS			<u> </u>		
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	ition Fast Ta	NKPOZP	7	SYST	TEM PS	P-4		EXAI	STAR	T 5840	EXAM 200		108# ひる- イ /
СОМ	PONENT ID	1	٥١.	- 22 -	P			EXA	AINATIC	SURFAC	Æ	CO	NDITION
	IGURATION		<u>01-</u>					CALL	BRATE	RANGE		**	TEMP OF
CIRC	UMFERENCE/I	TOTAL LENGT	TH EXA	MINEC	PLAT			REF.	LEVEL	CORRECT	3,5	NS. CORF	Ama of
990	CEDURE	· · · · · · · · · · · · · · · · · · ·				13.	REV		RIAL T				'Q' DB
Co	4 EMA	SYUT-	E~	<u> </u>	307.		1	_ □ s	s 🖂	CS OTH	IER	<u> </u>	14k875
FILE	NAME/ITEM#	VERT	انیا	ڪن	0/3	741	٤5	TRAI	ISDUCI DUAL	ER F⊒•SGL	☐ 00t	EG 5 27A	NGLE <u>60°</u>
	F. POINT (Lo)			Yo R	EF. POIN	T (Wo)		SCAL	V WIDT		.2^	,	
<u> </u>	SIZING ME	THOD	ر جد		NGLE	R	FERENCE C	AL SHE	ET T	• •	-	SET-U	P
	45/60 DEGR												
	AATT		\bot										
	RATT DUAL 0 DEC	REF				+-							
-	DOALODE	INEC				VDIC/	ATION INFO	RMAT	ION				
IND	METHOD	WELD SIDE	DEP R. L		MAX AMP	X1	LENGTH		YT	WII	DTH	Y2	INDICATION TYPE
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	SCGN L		<u> </u>	20	1 15 5	~=-	FOOM		-	8 L D#			

4/00		NIC P-SCAN REPORT				Piser# 31
LOCATION 200 EAST TANK FARM	SYSTEM	P-4	EXAM STAR		YAM FND	JOB#
COMPONENT ID	/	1		ON SURFACE		CONDITION
CONFIGURATION	- AP		CALIBRATE	DID PAI	NIED	TEMP
PLATE		E	00	TA /	414"	AMB OF
CIRCUMFERENCE/TOTAL LENGTH EX	AMINEU	B8.1"		CORRECTION	(TRANS. CC	<u>. ⊗</u> 08
COGEMA-SVUT-INS	- 007.3	REV	MATERIAL T	YPE CS OTHER		Mk ,500"
FILE NAME/ITEM#	LD 145/P	LATE 2	TOANCOLLO			ANGLE 450
X, REF. POINT (LA)	Ye REF. POINT	Wo)	SCAN WIDT	H)/	2,9"	
SIZING METHOD	ANGLE	REFERENCE C	AL SHEET		SET	-UP
1 45/60 DEGREE SHEAR			, ic. of izza	<u> </u>		<u></u>
2 AATT						
3 RATT						
4 DUAL 0 DEGREE						
IND METHOD I WELD DE		DICATION INFO		11467	1 1 1/2	LINDICATION
	PTH MAX LIG. AMP	X1 LENGTH	X2 Y1	WIDTI	H Y2	INDICATION TYPE
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NO Crack Like I	indication	MS				
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Level I Date 1/18/03 PScan Limited.	Level XX	Date 4/4/03	Level_	Date		

(P) See Attached Letter From J. B Elder

4/00		SONIC A REF	P-SCAN PORT					Riser#31
LOCATION 200 EAST TONK FORM	SYSTEM	59-4		EXAMS	TART		MEND	JOB#
COMPONENT ID		<u> </u>		EXAMIN	ATION S	URFACE		CONDITION
CONFIGURATION	TO			CALIBR	ATED RA	D PAINT		AMB of
CIRCUMFERENCE/TOTAL LENGTH E			41	REF. LE	VEL COE	RECTION (T	RANS. CO	RR)
		80,8			•			<u>. & DB</u>
PROCEDURE COGEMA-SVUT-INS.	- 007.3	<u> </u>	REV	□ SS	AL TYPE			NK .5625"
CR C MARKETERS	ELD/45/	PLAT	£3	TRANS	DUCER DUAL 4	SISGL □	DEG 2	ANGLE 45°
Xo REF. POINT (Lo)	REF POIN	IT (Wo)	\~\.\	SCAN W		10.		
SIZING METHOD	ANGLE	RI	FERENCE C	AL. SHEE	T T	•	SET	-UP
1 45/60 DEGREE SHEAR								
2 AATT		<u> </u>						· · · · · · · · · · · · · · · · · · ·
3 RATT 4 DUAL 0 DEGREE			 -					
4 DUAL 0 DEGREE		NOICA	TION INFO	RMATIC	 NAI			
	EPTH MAX	X1	LENGTH		Y1	WIDTH	Y2	INDICATION TYPE
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REMARKS No Crack LI	ke Ind	icat	ions					
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P-Scan Limited	Level	Date	4)9/03	Leve	el	Date		of

4/00		SONIC A REF	P-SCAN PORT					Riser# 31
LOCATION 200 EDST TANK FORM	SYSTEM P	SP-4		EXAM	START		NW END	JOB# 03-4\
COMPONENT ID	1-AP			EXAM	ILNATIO	N SURFACE □ ID □ PAINT		CONDITION
PLATE	PLA	775		CALIE	RATED	RANGE	- 11	TEMP OF
CIRCUMFERENCE/TOTAL LENGTH	XAMINED		1.5"	REF,	LEVEL	CORRECTION (RANS. CO	RR) 💍 DB
PROCEDURE COGEMA -SUUT-IN	S ~ 007.3	F	REV	MATE	RIAL T	YPE		0K. 1750"
EILE NAME/ITEM#	, METD/	1000	DIATE S	TRAN	SDUCE			ANGLE U5°
Xo REF. POINT (Lo)	Y. REF. POIN	T (Wo)	Weld		WIDTH	SSTSGL []	.64	ANGLE SO
SIZING METHOD	ANGLE		FERENCE C	AL. SHE	ET		SET-	UP
1 45/60 DEGREE SHEAR		=						
2 AATT 3 RATT		+-	-		_			<u> </u>
4 DUAL 0 DEGREE								
IND I METHOD I WELD I D	II DEPTH I MAX		TION INFO			1111571	13/2	LINDICATION
	R. LIG. AMP	X1	LENGTH	X2	Y1	WIDTH	Y2	INDICATION TYPE
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REMARKS .	1	<u> </u>	J		<u> </u>			
No Crack Like	Zudio	ccłi	sw2			-		
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4/00				ULTRAS DATA	ONIC A REF				. •		eiser=31
LOCA	TION S EAST TO	VK 606	S	YSTEM P	3P-4	ł	EXAM	START	815	EXAMEND 1945	JO8# 03-41
	ONENT ID) 1 - F			<u> </u>	EXAM	INATION	SURFACE		CONDITION
CONF	IGURATION			10 - PLA	72		CALIE	RATED	ANGE		TEMP OF
CIRCI	JMFERENCE/T	TAL LENGT		NCO	<i>`8</i> "		REF.	LEVEL C	ORRECTION	(TRANS.	CORR) DB
PROC	EDURE					REV	MATE	RIAL TY	PE		
FILE	EMA -S						TOAN	COLLOCO	S OTHER		TAK. ,875"
X ₀ RE	F. POINT (Lo)	VER	<u>۲. س</u>	YOREF, POINT	15/ 5	CATE 5	SCAN	DUAL	SGL		RANGLE US
lu F	H WOIS		4	YOREF, POINT	Ver	weld					T-UP
1 4	SIZING ME 15/60 DEGR			ANGLE		FERENCE C	AL. OHE	- 		30	.FUF
2 /	AATT										
	RATT DUAL 0 DEC	POEE						_			
-	DOAL O DEC	JACE .		11	VDICA	TION INFO	RMAT	ION			
IND	METHOD	WELD SIDE	DEPT R. LIC		X1	LENGTH	X2	Ŷ1	רסוש	H Y2	INDICATION TYPE
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	No C	rack	Lik	e Ind	ica	tions					····
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	4/00	AUI		DULTRAS DATA RE	SONIC THIC	KNESS	- -	0	.15er# 31
	LOCATION 200 FAST		SYST			1/6	START 03 08:	EXAMEND 1950	J08#
	COMPONENT ID	1	UI-AF	>		57	NATION SURF	PAINTED	NOM, THICKNES
	CONFIGURATIO	N PLA	TO	KNUCK	UK.	CALISA	ATED RANGE	1.0"	TEMP
	CIRCUMFERENC	CE/TOTAL LENGI	H EXAMINED	25,		REF. LI	EVEL CORREC	CTION (TRANS. CO	ORR) & DB
	PROCEDURE COGEM	A - SVUT	- ZNS -	007·3	REV /	SS	KALTYPE SOCS O	THER	CONDITION
Ì	FILE NAME/ITEM	HORZ.	بيوس	PLATE	BAUCKLE	120		GL 🔀 ODEG 🖸] ANGLE
	Xo REF. POINT (North Air I	146 6	of Hop	z weld	SCAN		1013"	
	PART#1. INDICATION	X START	X STOP	YSTA	RT YSTOP	THK.	MIN. THK R. LIG	AREA REPORTABLE	NUX THK
- }	0-12				:	975			·885·*
274	12-21	<u> </u>				876"	.872'		.885
·	24- 34	<u> </u>	 		 	1876"	.868"		1885
. [36-48	<u> </u>				,8764	.867"		.865*
	41-60		<u> </u>			8774	.869^		.885"
	60-6514					. 977*	.867"		, 865°
ŀ	0-12					1925"	.9/3"		,945"
أبلان	12-24					19300			1940"
الاعتباد	24-36					95"	9107		4350
ĺ	36-48					923"	1898"		930 "
Ī	48-60				1.	,920"	.884"	<u></u>	930"
	60-65.4					,920^	, 907"		938"
	SUMMARY								
	REMARKS	<u> </u>	,			<u> </u>		<u> </u>	<u> </u>
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	Level I [<u>23</u>	Level	S Date //	2 <u>9/0</u> 3	Level	Date	_

			ATA REPO	DRT	·····			Iser#
LOCATION TO SOLUTION	any Fag	SYSTE	M PSP-4		EXAMS		EXAMEND 1950	103.41
COMPONENT ID	10	AP - اد		-	EXAMIN	VATION SURF.	ACE	NOM THICK
CONFIGURATION	PLAT	ان ان	KNUCK	LE	CALIBR	-3 TO		TEMP
CIRCUMFERENCE/			120"		REF. LE	VEL CORREC	TION (TRANS. CO	RR) &
PROCEDURE COGEMA	<i>-</i> 574 T-	Z~> - C	1	EV /		IAL TYPE	THER	CONDIT
FILE NAME/ITEM#	12 H 127	コアタコヴ	Aksuc	KLLE A	TRANS	DUCER		ANGLE
X REF. POINT (La)	REP AIR S	LA YARE	F. POINT AVAI		SCANV	YIOTH	10,3	
PART#/ INDICATION	X START	X STOP	YSTART	Y 510P	AVE, THK.	MIN. THK, R. LIG.	AREA REPORTABLE	MAX THK
0-12			• :		,875"	.865"		,885
12-24				<u> </u>	. 878"	.869"		885
24.36				1	เธาช"	.856"		.885
36-48					, ୫୩୫"	1824,		685
48-60		,			, 877"	.970"		.885
48-60					.876"	.866"		, 885
72-84	•				.875"	.866		. 885
84.96					.876"	. 866"		, 995
96-108					,876	1874"		.885
108-120					.876"	.861"		.865
				<u> </u>				
SUMMARY	·					•		1
REMARKS		 :-		L	· · ·			<u> </u>
Started	کے لوع	ייר.	of Ei	le P	ate K.	vuckle	<u> </u>	
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10017:01	<u></u>	D. J systea	ATA REPO	RT	L ev.		(وجييع	r = 5/	
LOCATION .	TONK FO		PSP4		EXALL	START 3. OB Bo	EXAMEND 1950	\$ 60f	-43	1
COMPONENT IS)				EXYM	VATION SURF	ACE	NOV	. THICKNESS	1
		<u> 의 - AP</u>			<u>8</u>	00 🗆 10	PAINTED		737"	
CONFIGURATIO	<u> </u>		جمابرز	LE.		ATED RANGE	0 10"	_	remp Amb "F	}
CIRCUMFEREN	CE/TOTAL LENGT	H EXAMINED	1207		REF. L	EVEL CORREC	TION (TRANS. CO	ORR)	\$2 DB] '
PROCEDURE			I R	EV /		IAL TYPE		10	CONDITION	1
EN E MALIENTEN	<u>a - Syur</u>				TDANC	ZÓCS O DUCER	THER			-
1-10	ez. WEL	D' PLA	TE/KN	HCKLE	A S		SL 200EG [] ANGLE		
XOREF. POINT (La) 3 to Air S	YOREF	POINT (Wa)	الماملان	SCAN		10.5			
PART#/ INDICATION	X START	X STOP	YSTART	YSTOP .	AVE.	MIN, THK,	AREA	MAX.T	HK.	1
D-12	 	 	 		THIC	R.UG.	REPORTABLE	1	25"	-
12-24	 	i	- -	 	,9/5	.897"		197		1
24.36			1		,915"	.889"			25"	1
36-46					.912"	906"		19	25"	1 .
40-60	1	·	,		. 420"	898"		1.9	50"	CEOS!
60-12					.948"	9.39*			50"	VIDEX.
72-84					947	920"			50"	~ ω _E π
84-96				i	1947"	924			50"	1
96-108					. 448"	.135			50"	1
1043-120					.449	.922			33.	
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SUMMARY		1						!		
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REMARKS		·								
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	OCATION OUO EAST T	ያለት ድላይ		E PSES	1		iari 2 083 0	/950	103#	
Ī	OMPONENT ID		N-AP			EXAMIN	ATION SURF	ACE	NOM THICKNESS	1
7	CONFIGURATION	PLAT	TO			CALISA	ATED RANGE		TEMP	1
(CIRCUMFERENCE			61.9°		REF. LE	YEL CORRECT	CTION (TRANS. CO	RR) & DB	1
	ROCEDURE				REV /		AL TYPE	T. 150	CONDITION	1
1	TOGET P	1-5V41-	1 レノ I 7かユ	007.5		TRANS	<u>pa</u> cs o	THER		-[
Ļ	ILE NAME/ITEM#	HORZ WOL	a hlate	EF! POINT (Wa)	<u>e B</u>	∑ 3	NAL DSC	SL 53 ODEG [ANGLE	
1	G KET. POINT (Lo		Ten	EF. POINT (Wa)		SCAN	HTDIN	10,3"	•	1
	PART#1 NDICATION	X START	X STOP	YSTART	Y STOP	AVE. THK	MIN. THK, R. LIG.	AREA REPORTASLE	NAX. THK.	1
_	0-12					,978			1885"]
·[]	2-24					. 876"	.873"		. 895"]
	24-36					,880"	.867"		,985"] ′
3	86-48					1881	.875"		1895	1
4	18-60"					.688.	1854"		.890"].
4	60-61.9				ļ	1882"	.875"		890"	-
\vdash					<u> </u>	ļ				4
-	<u> </u>					Out out			0.50"	
ս–	0-12				 	.948"	924"		.955"	┨
:	12-24	· · ·				946	.936		,955*	-
	24-36				<u> </u>	942"	, ૧૦૭*		955"	-
-	3648				 	1942,	,922"		955	ceo
-	48-60				.	964	926	·	,970''	1 750
\vdash	60-61.9				- 	1963	<u>.955°</u>		1975	ا ئن
1	SUMMARY				<u> </u>	 			 	┨
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-	REMARKS		•		1				<u></u>	1
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4/00		DATA		P-SCAN PORT						Riser 31
Location 200 East Tank Farm	SYST	EM PSP-	L		EXAM	STAF	^श ८ <u>८५</u> ०	EXAM		108#
COMPONENT IN	<u>۱۰</u>				EXAM	IINATI	ON SURFAC	Ē	TC	ONDITION
CONFIGURATION	70	<u> </u>			CALIE	RATE	D ID D			TEMP
PLATE	- V 4 4 314 12 5	KNU				0'	CORRECTI	1.75	и	AMB OF
CIRCUMFERENCE/TOTAL LENGTH	EXAMINEL	6	3.7	^	REF.	LEVE	L CORRECTI	ON (TR	ANS. COP	(R) · 🐠 DB
PROCEDURE COGEMA-SUT -: FILE NAME/ITEM#			F	REV 1			TYPE CS OTH	ER	TμŢ	<u> </u>
HORZ. WELD	PLA	TE /KN	الاجه	<u>. LE</u>		DUA	L 53 SGL	00	EG 🖫	ANGLE 60°
XOREF. POINT (Lo) STANKO NORTH ARE LEVE	Yo F	EF. POINT	(W₀)	WKO	SCAN	WIDT	TH /	0.3		
SIZING METHOD	A)	IGLE	R	FERENCE C	AL. SHE	ET	<u> </u>		SET-L	JP .
1 45/60 DEGREE SHEAR										
2 AATT										
3 RATT	ļ									•
4 DUAL 0 DEGREE	<u></u>	786		TION INFO		- I	<u> </u>			
	DEPTH R. LIG.		X1	LENGTH		Y1	WIG	тн.	Y2	INDICATION
				 			 			
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REMARKS NO CRACK LIK	Z. 2))DE	<u>.ar</u>	3025				-		
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+2-Scan Limited		1 15 5					· · · · · · · · · · · · · · · · · · ·			<u> </u>

4/00	ULTRAS DATA						R	erser31
LOCATION 200 EAST TANK FARM	SYSTEM PSP-	. L J		EXA	ASTART	EXAL 2.0	,	03-41
COMPONENT ID				EXAM	NOITANIN	SURFACE	CON	VDITION .
CONFIGURATION	10 TO				OD D	ID PAINTE	D [ート L TEMP
PLATE	KNU	CKL	<u></u>		0"	r. 3.75		AMB OF
CIRCUMFERENCE/TOTAL LENGTH EX	AMINED	20"		REF.	LEVEL CO	RRECTION (TR	RANS. CORR) <u>(</u> DB
PROCEDURE			REV	MATE	RIAL TYP	E	THE	
COGEMA-SUT-S	· · · · · · · · · · · · · · · · · · ·		<u> </u>	TRAN	S ET CS			Α
HORZ WELD	PLATE L	كتنح	xue A		DUAL	STSGL □ 00	DEG IS VAI	NGLE <u>60°</u>
XO REF. POINT (Lo) VERT. WILLO	TO KET POINT	(Wo) • • • • • • • • • • • • • • • • • • •	LANKICO	SCA	HTOIW	10.3		
SIZING METHOD	ANGLE	R	FERENCE C	AL. SHE	ET		SET-UF	2
1 45/60 DEGREE SHEAR								
2 AATT		-						
3 RATT		-		<u> </u>				
4 DUAL 0 DEGREE	141	DICA	TION INFO	DAAAT			· ·	
IND METHOD I WELD DE	IN TH MAX	X1	LENGTH	X2	ION I Y1	WIDTH	l Y2	INDICATION
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REMARKS			<u> </u>				<u> </u>	
NO CRACK LIKE	E TWDE	cat	30/75	·		·		
Examiner	Analyst	1/1/	<u> </u>		viewer		T	Page
Level I Date 1/4/05 P. Scan Limited	Level WK	Date	4/17/03		vel	Date		of
	ده سادم	UE O	Feon	~ 7	B. 8	ELDEN.		

4/00				DATA		P-SCAN PORT						iscr31
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COMPONEN	TID					·		XAMINATIO	ON SUF	RFACE	CO	IDITION
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	ENCE/TOTAL LENG		AMINEC)	60	۰, 2"	R	EF. LEVEL	CORR	ECTION (TR	ANS, CORR	. 💪 DB
PROCEDURE	mA-syy			7.0 2	_ ` 	REV		MATERIAL 1		ATUCO	עעד	_ ,ers"/.937"
FILE NAME/	TEM#			i	سا برای	nucket B		SS EXTRANSDUC				NGLE 60°
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Level III P-Sca	Date 1/8			vel vel		4/17/03		Level		Date		of

Att. 3-53

4/00				DAT	SONIC A REF	P-SCAN PORT					Riser#31
LOCA 2 o	TION O EAST TO	ink for	SYS	TEM PSP	- 4		EXAM	ASTART		XAM END	JOB# 03-41
COM	ONENT ID						EXAM	MINATION	SURFACE		CONDITION
000	IGURATION	10	<u>1 - 1 C</u>		·				DANCE PAIN	VTED	TEMP
CONF	GURATION	PLAT			UCK	لگانا.	CALII	BRATED	To 2.	45"	Ame of
CIRCI	UMFERENCE/	TOTAL LENGTH		n	າວ^		REF.	LEVEL C	ORRECTION	(TRANS. C	
	EDURE				F	REV		RIAL TY		ئات	N "
	NAME/ITEM#	-51UT-	<u> 202 -</u>	<u>007.</u>	3			s. E C Isducer			<u> </u>
		HORZ.	WEG	3/45	/knu	ILXLLS /PU	> 1€	DUAL	、 ₩ESISGL []	ANGLE 45
X _o RE	F. POINT (Lo) :	3 to 5 lot	Yo	REF. PQIN	(Wo)	weld	SCAN	MIDTH	11,		
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1 .	45/60 DEGR		<u> </u>	NGLE		FERENCE C	AL. SHE	C1	· · · · · · · · · · · · · · · · · · ·	SE	1-0P
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Pev.	el <u>TL</u> Da Scan L	le <u>1-15-03</u>	_ Le	vel	/Date	4112/03	Le	vel	_ Date		of

LOCATION 200 EAST TANK FARM PSP-Y COMPONENT ID CONFIGURATION TO CONFIGURATION TO CIRCUMFERENCE/TOTAL LENGTH EXAMINED PROCEDURE COGEMA-SYUT-ENS-007.3 FILE NAME/ITEM# TRANSDUCER TO SYREF POINT (Lo) 30 5101 Yo REF. POINT (Wo) SIZING METHOD ANGLE REFERENCE CAL. SHEET 1 45/60 DEGREE SHEAR	CONDITION TEMP TEMP TEMP OF
COMPONENT ID CONFIGURATION TO CIRCUMFERENCE/TOTAL LENGTH EXAMINED PROCEDURE COGEMA-SYUT-E-SS-007.3 FILE NAME/ITEM# VOREF POINT (Lo) 35 SLOT YO REF POINT (Wo) SIZING METHOD ANGLE EXAMINATION SURFACE CALIBRATED RANGE CALIBRATED RANGE CALIBRATED RANGE MATERIAL TYPE TRANSDUCER TRANSDUCER DUAL SIGL DODE SCAN WIDTH 1.	CONDITION TEMP PMS OF NS. CORR) DB TIX: .875".937"
CONFIGURATION TO CIRCUMFERENCE/TOTAL LENGTH EXAMINED PROCEDURE COGEMA-5YUT-E-55-007.3 FILE NAME/ITEM# ADEC: WESU /45 / KNUCKUS TO 2.65 REF. LEVEL CORRECTION (TRA MATERIAL TYPE SS TO S OTHER TRANSDUCER DUAL SISS DOE SCAN WIDTH 1. SIZING METHOD ANGLE REFERENCE CAL. SHEET	" Pmg of NS. CORR)
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PROCEDURE COGEMA-SYUT-E-SS-007.3 FILE NAME/ITEM# FILE NAME/ITEM# TRANSDUCER DUAL SIGL DOE SCAN WIDTH SIZING METHOD ANGLE REFERENCE CAL SHEET	
FILE NAME/ITEM# FILE NAME/ITEM# TRANSDUCER TRANSDUCER DUAL SIGL DOE SCAN WIDTH SIZING METHOD ANGLE REFERENCE CAL SHEET	
FILE NAME/ITEM# WORZ: WISCO /45 / KNYCKLE / PLOTE A TRANSDUCER DUAL SIGL DOE Xo REF. POINT (Lo) 3 SLOT YO REF. POINT (Wo) SIZING METHOD ANGLE REFERENCE CAL. SHEET	
SIZING METHOD Xo REF. POINT (No.) SIZING METHOD SIZING METHOD SCAN WIDTH SCAN WIDTH ANGLE REFERENCE CAL. SHEET	G RIANGLE 13
SIZING METHOD ANGLE REFERENCE CAL. SHEET	
1 43/00 DEGREE SHEAR	SET-UP
2 AATT	<u> </u>
3 RATT	
4 DUAL 0 DEGREE	
INDICATION INFORMATION	
IND METHOD WELD DEPTH MAX X1 LENGTH X2 Y1 WIDTH SIDE R. LIG. AMP	Y2 INDICATION TYPE
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SIGNAL	CABLE COAX						CABL	E LEN	GTH F1	-	CAB	LE#	
CHANN	EL TRANSDUC	ER	MODEL	FR		SIZE	SERIA	L#	GATE E	/AL	ANGLE NOM/A	WEDG	E IMAGE
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SCANNE			•		· · · · · · · · · · · · · · · · · · ·	٠.					GTH FT	-	CAB	LE#		
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4/00		AU'		MATED UL' CALIBRA			CAN			03-4	
PROCE	AST TANK	1-APM	SYST	HP-10		ser 31	NOT C	Block	5	84-99-36 MATERIAL	ما14ء
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	CABLE CAY		٠.				CABLE LEN		CABL		
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P-Sco	IN SUS !	4 1.3	2	· .			•		NI	A		MATERIA!	<u> </u>
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j	NITIAL CALIBR	ATION	T .			CALIBI	RATI	ON CHE	CKS				
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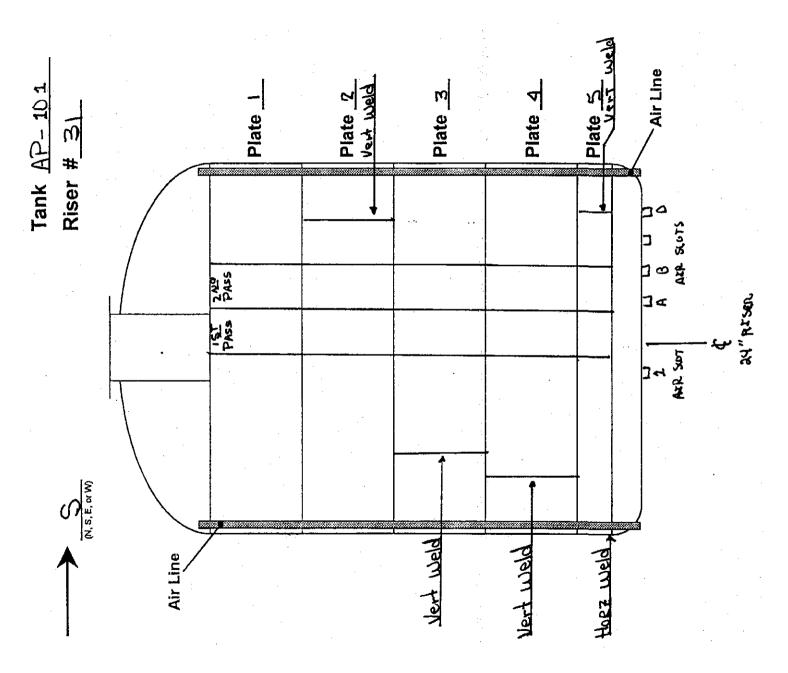
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April 8th. 2003

Mr. Daron Tate COGEMA Engineering Corp. 2425 Stevens Center Richland, WA, 99352

This letter is to certify that I have analyzed the P-scan automated ultrasonic data from Hanford waste tank AP 101. The data reviewed for the primary tank wall was collected by Mr. Nelson and Mr. Purdy October 30th, through March 18th, 2003. The data is acceptable. The data from vertical strips, vertical welds, horizontal weld, the primary knuckle examination with the extended Y-arm and 4 slots examined with the extended Y-arm was analyzed to the requirements of COGEMA procedure SVIIT-INS-007.3 Revision 1.

There were no reportable indications. No cracking, reportable pitting or other reportable thinning was detected in any of the areas examined.

James B. Elder

ASNT UT Level III

CC: Mr. W. H. Nelson - COGEMA

ATTACHMENT 4

COGEMA "SAFT/T-SAFT ULTRASONIC DATA REPORT SHEETS"

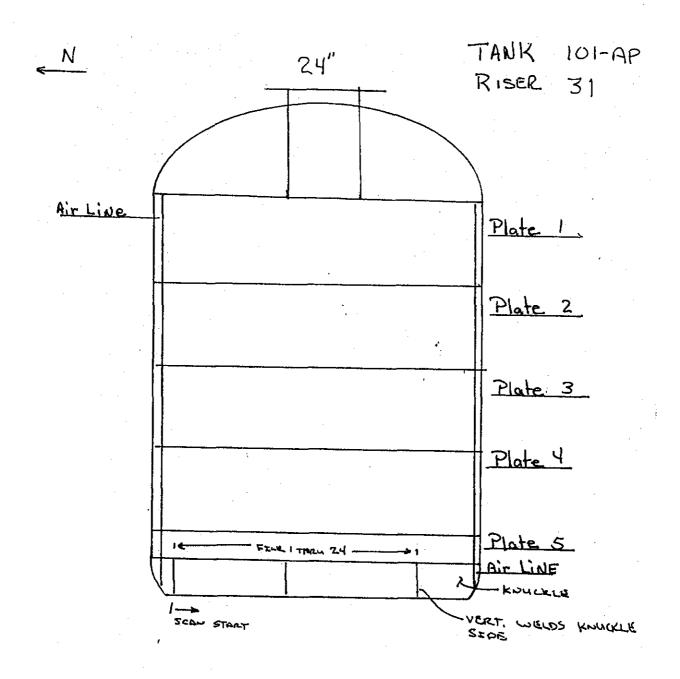
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ATTACHMENT 4

COGEMA "SAFT/T-SAFT ULTRASONIC DATA REPORT SHEETS"

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ATTACHMENT 5

ULTRASONIC EXAMINATION OF DOUBLE-SHELL TANK 241-AP-101 EXAMINATION COMPLETED MARCH 2003 (PNNL THIRD PARTY REVIEW) This page intentionally left blank.

Ultrasonic Examination of Double-Shell Tank 241-AP-101 Examination Completed March 2003

AF Pardini GJ Posakony

April 2003

Prepared for the U.S. Department of Energy under Contract DE-AC06-76RL01830

Pacific Northwest National Laboratory Richland, Washington 99352 This page intentionally left blank.

Summary

COGEMA Engineering Corporation (COGEMA), under a contract from CH2M Hill Hanford Group (CH2M Hill), has performed an ultrasonic examination of selected portions of Double-Shell Tank 241-AP-101. The purpose of this examination was to provide information that could be used to evaluate the integrity of the wall of the primary tank. The requirements for the ultrasonic examination of Tank 241-AP-101 were to detect, characterize (identify, size, and locate), and record measurements made of any wall thinning, pitting, or cracks that might be present in the wall of the primary tank. Any measurements that exceed the requirements set forth in the Engineering Task Plan (ETP), RPP-11832 (Jensen 2002), are reported to CH2M Hill and the Pacific Northwest National Laboratory (PNNL) for further evaluation. Under the contract with CH2M Hill, all data is to be recorded on disk and paper copies of all measurements are provided to PNNL for third-party evaluation. PNNL is responsible for preparing a report(s) that describes the results of the COGEMA ultrasonic examinations.

Examination Results

The results of the examination of Tank 241-AP-101 have been evaluated by PNNL personnel. The examination consisted of two 15-in. wide scans over the entire height of the tank, the heat-affected zone (HAZ) of four vertical welds and one horizontal weld, and examination of the knuckle region. The examination was performed to detect any wall thinning, pitting, or cracking in the primary tank wall.

Primary Tank Wall Vertical Scan Paths

Two 15-in.-wide scan paths were performed on Plates #1, #2, #3, #4, and #5. The plates were examined for wall thinning, pitting, and cracks oriented vertically on the primary tank wall. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or vertical crack-like indications were detected in Plate #1, #2, #3, #4, or #5.

Primary Tank Wall Weld Scan Paths

The HAZs of vertical welds in Plates #2, #3, #4, and #5 were examined for wall thinning, pitting and cracks oriented either perpendicular or parallel to the weld. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld areas in Plate #2, #3, #4, or #5.

The HAZ of the horizontal weld between Plate #5 and the tank knuckle was examined for wall thinning, pitting and cracks oriented either perpendicular or parallel to the weld. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld areas on Plate #5 side or on the knuckle side of the horizontal weld.

Primary Tank Wall Knuckle Scan Paths

The upper portion of the knuckle area was scanned utilizing the Y-arm scanner attached to the AWS-5D crawler. The Y-arm scanned the transducers down around the knuckle approximately 12-in. from a starting position 2-in. down from the upper knuckle weld joining Plate #5 to the knuckle. The knuckle was examined for wall thinning, pitting, and cracks oriented circumferentially around the primary tank. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or circumferentially oriented crack-like indications were detected in the upper portion of the knuckle area.

Four small areas on the lower portion of the knuckle area were examined for wall thinning only utilizing the Y-arm scanner in areas accessible through selected air slots. The four areas examined were in air slots designated as Slot1, Slot A, Slot B, and Slot D. There were no areas that exceeded the reportable level of 10% of the nominal thickness.

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1.0 Introduction

COGEMA Engineering Corporation (COGEMA), under a contract from CH2M Hill Hanford Group (CH2M Hill), has performed an ultrasonic examination (UT) of selected portions of Double-Shell Tank (DST) 241-AP-101. The purpose of this examination was to provide information that could be used to evaluate the integrity of the DST. The requirements for the UT of Tank 241-AP-101 were to detect, characterize (identify, size, and locate), and record measurements made of any wall thinning, pitting, or cracks that might be present in the wall of the primary tank. Any measurements that exceed the requirements set forth in the Engineering Task Plan (ETP), RPP-11832 (Jensen 2002), are reported to CH2M Hill and the Pacific Northwest National Laboratory (PNNL) for further evaluation. Specific measurements that are reported include the following:

- Wall thinning that exceeds 10% of the nominal thickness of the plate.
- Pits with depths that exceed 25% of the nominal plate thickness.
- Stress-corrosion cracks that exceed 0.10-in. (through-wall) that are detected in the inner wall of the tank, heat-affected zone (HAZ) of welds, or in the tank knuckle.

The accuracy requirements for ultrasonic measurements for the different types of defects are as follows:

- Wall thinning measure thickness within ± 0.020 -in.
- Pits size depths within ± 0.050 -in.
- Cracks size the depth of cracks on the inner wall surfaces within ± 0.1 -in.
- Location locate all reportable indications within ± 1.0 -in.

Under the contract with CH2M Hill, all data is to be recorded on disk and paper copies of all measurements are provided to PNNL for third-party evaluation. PNNL is responsible for preparing a report(s) that describes the results of the COGEMA UT.

2.0 Qualified Personnel, Procedures, and Equipment

Under contract from CH2M Hill, qualification of personnel participating in the DST inspection program, the UT equipment (instrument and mechanical scanning fixture), and the UT procedure that will be used in the examination of the current DST is required. Personnel participating in the examinations are to be certified in accordance with American Society for Nondestructive Testing (ASNT) Guideline SNT-TC-1A-92 and associated documentation is to be provided. The capability of the UT system is to be validated through a performance demonstration test (PDT) administered by PNNL on a mock-up simulating the actual DST. The current procedure for the UT is to be based on the Section V, Article 4, Boiler and Pressure Vessel Code defined by the American Society for Mechanical Engineers (ASME).

2.1 Personnel Qualifications

The following individuals were qualified and certified to perform UT of the Hanford DST 241-AP-101:

- Mr. Wesley Nelson, ASNT Level III (#LM-1874) in UT, has been identified as COGEMA's UT
 Level III authority for this project. Mr. Nelson has been certified by COGEMA as a UT Level III in
 accordance with COGEMA procedure COGEMA-SVCP-PRC-014, latest revision. Further
 documentation has been provided to establish his qualifications. Reference: Letter from PNNL to
 C.E. Jensen dated August 22, 2000, "Report on Performance Demonstration Test PDT, May 2000."
- Mr. James B. Elder, ASNT Level III (#JM-1891) in UT, has been contracted by COGEMA to provide peer review of all DST UT data. Mr. Elder has been certified by JBNDT as a UT Level III in accordance with JBNDT written practice JBNDT-WP-1, latest revision. Further documentation has been provided to establish his qualifications. Reference: PNNL-11971, Final Report Ultrasonic Examination of Double-Shell Tank 241-AN-107.
- Mr. William D. Purdy, COGEMA UT Level II limited (for P-Scan data acquisition only).
 Mr. Purdy has been certified in accordance with COGEMA procedure COGEMA-SVCP-PRC-014, latest revision. Further documentation has been provided to establish his qualifications. Reference: Letter from PNNL to C.E. Jensen dated October 5, 2001, "Purdy Performance Demonstration Test (PDT) Report."

2.2 Ultrasonic Examination Equipment

CH2M Hill has provided the UT equipment for the examination of Tank 241-AP-101. This equipment consists of a Force Institute P-Scan ultrasonic test instrument and a Force Institute AWS-5D remote-controlled, magnetic-wheel crawler for examining the primary tank wall. The examination of Tank 241-AP-101 also included utilization of the Y-arm scanning bridge. Ultrasonic transducers used for the examinations are commercial off the shelf. The P-Scan ultrasonic system and Y-arm scanner attachment have been qualified through a PDT administered by PNNL. Reference: PNNL-11971, Final Report- Ultrasonic Examination of Double-Shell Tank 241-AN-107 and letter from PNNL to C.E. Jensen dated September 21, 2001, "Qualification of the Y-Arm Attachment".

2.3 Ultrasonic Examination Procedure

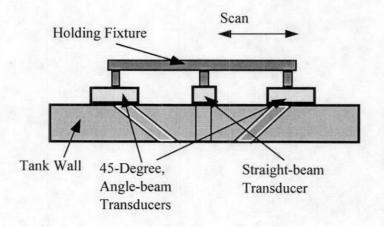
COGEMA-SVUT-INS-007.3, Revision 1, outlines the type of UT and mechanical equipment that are to be used as well as the types of transducers. Both straight-beam and angle-beam transducers are used for the examination of the primary tank wall. The examination procedures include full documentation on methods for calibration, examination, and reporting. Hard copies of the T-Scan (thickness) and P-Scan (projection or angle beam) views of all areas scanned are made available for analysis. The UT procedure requires the use of specific UT transducers for the different examinations. A calibration performed before and after the examinations identifies the specific transducers used and the sensitivity adjustments needed to perform the inspection. The COGEMA UT procedure has been qualified through a Performance Demonstration Test. Reference: PNNL-11971, Final Report - Ultrasonic Examination of Double-Shell Tank 241-AN-107.

3.0 Ultrasonic Examination Configuration

COGEMA is required to inspect selected portions of the DSTs which may include the primary and secondary tank walls, the HAZ of primary tank vertical and horizontal welds, and the tank knuckle and bottoms. The P-Scan system has been configured to perform these examinations and has been performance tested. The examination of Tank 241-AP-101 included UT of the primary tank wall, the HAZ of selected welds in the primary tank wall, the upper portion of the knuckle extending axially downward from the upper knuckle weld approximately 12-in., and selected portions of the knuckle in the air slot openings that extended to the lower knuckle weld.

3.1 Primary Tank Wall Transducer Configuration

Figure 3.1 provides an example of the scanning configuration generally used during an examination of the primary tank wall. However, other configurations can be used at the discretion of the COGEMA Ultrasonic Level III (i.e., 45-degree transducers can be removed for simple wall thickness measurements). The functional diagram in Figure 3.1 shows one straight-beam and two angle-beam transducers ganged together for examining the primary tank wall. The straight beam is designed to detect and record wall thinning and pits, and the angle beams are designed to detect and record any cracking that may be present. These transducers are attached to the scanning bridge and they all move together. Information is captured every 0.035-in. (or as set by the NDE inspector) as the assembly is scanned across a line. At the end of each scan the fixture is indexed 0.035-in. (or as set by the NDE inspector) and the scan is repeated. The mechanical scanning fixture is designed to scan a maximum of 15-in. and then index for the next scan. The hard copy provides a permanent record that is used for the subsequent analysis.



Transducer Specifications:

Angle-beam

Type: MWB-45 04E Frequency: 4 MHz Size: 8 X 9 mm.

Manufacturer: Krautkramer

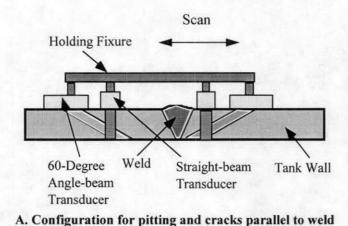
Straight-beam

Type: MSEB 5B Frequency: 5 MHz Size: Dual - 8 X 2 mm Manufacturer: Krautkramer

Figure 3.1. Transducer Configuration for Examining the Primary Tank Wall

Weld Zone Transducer Configuration 3.2

Figure 3.2 is a functional sketch that shows the configurations for examination of the weld zone. The area of interest (HAZ of the weld) is shown as lying adjacent to the weld. Both cracks and pitting may occur in this region. The "A" portion of this sketch shows the 60-degree angle-beam transducers used for detecting cracks parallel to the weld. The straight-beam transducers in this sketch are used for detecting and recording any pitting or wall thinning that may be present. All transducers are ganged together. The scanning distance traveled is limited to a total of 5.0-in. The sketch titled "B" shows the arrangement for detecting cracks that may lie perpendicular to the weld. Four 45-degree, angle-beam transducers are used for this inspection. Again the transducers are ganged together but the scan is limited to a total of 4.0-in. The weld zone requirements are shown in Figure 3.3. The scan protocol, data capture, and index are the same for examining other weld areas in the tank.



Transducer Specifications:

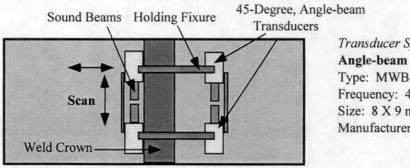
Angle-Beam

Type: MWB-60 04E Frequency: 4 MHz Size: 8 X 9 mm

Manufacturer: Krautkramer

Straight-beam

Type: MSEB 5B Frequency: 5MHz Size: Dual - 2 X 8 mm Manufacturer: Krautkramer



Transducer Specifications:

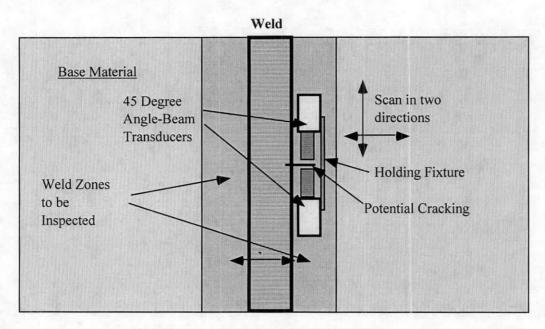
Type: MWB-45 04E Frequency: 4 MHz Size: 8 X 9 mm

Manufacturer: Krautkramer

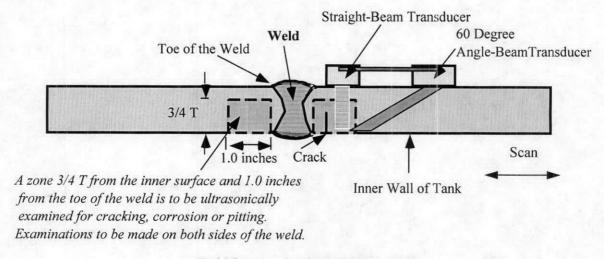
B. Configuration for cracks perpendicular to weld

Figure 3.2. Transducer Configurations for Examination of Weld Zone in the Primary Tank Wall

In the HAZ, the requirement for characterizing cracks that lie perpendicular or parallel to welds in the primary tank wall is described in Figure 3.3. The HAZs are located on either side of the weld and defined as being within 1-in. of the weld and on the inner three-quarters of the thickness (3/4T) of the plate. These zones are considered most likely to experience stress-corrosion cracking.



Top View - - - Cracks Perpendicular to Weld



End View - - - Cracks Parallel to Weld

Figure 3.3. Views of the Weld Zone to be Ultrasonically Examined in the Primary Tank Wall

3.3 Knuckle Area Transducer Configuration

Examination of the knuckle utilizes a modified scanning bridge known as the Y-arm scanner. The Y-arm provides scanning of the transducers directly on the knuckle region. The Y-arm is a special fixture that attaches to the AWS-5D magnetic wheel crawler. Its purpose is to extend the reach of the transducer assembly. This extension allows the transducer assembly to follow the curve of the upper portion of the knuckle below the transition Plate #5 to upper knuckle weld. It is designed to hold the dual 0-degree or two 45-degree transducers in the same configuration as used for the examination of the tank wall. The transducer configuration used for crack detection in this examination was two opposing 45-degree angle-beam transducers that were rotated 90-degrees from the orientation used for the wall crack inspection. This configuration is designed to detect cracks that are in a circumferential direction with respect to the axis of the tank. Figure 3.4 is a sketch showing the area of the section of the knuckle examined using the Y-arm fixture. With the transducer positioned 2-in, below the transition Plate #5 to upper knuckle weld, the scanning bridge was set to scan the transducer downward an additional distance of approximately 12-in, in 0.035-in steps (or as set by the operator). Upon completion of the scan, the bridge was indexed circumferentially 0.035-in. (or as set by the operator) and the scan downward is repeated to obtain a pixel size 0.035-in, x 0.035-in. (or as set by the operator).

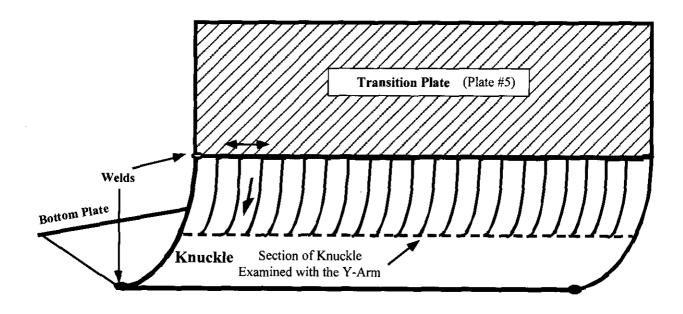


Figure 3.4. Sketch of a Section of the Knuckle Examined with the Y-Arm Scanner

Additional Y-arm scanning was done on areas that were accessible in the air slots that extend under the tank in the concrete support foundation. Figure 3.5 provides an end view (looking down the air slot) and Figure 3.6 provides a side view (looking along the circumference of the tank) of the examination of the lower knuckle in the region of the air slots.

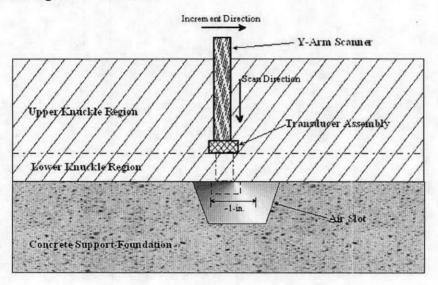


Figure 3.5. Lower Knuckle Examination in Air Slot Regions (End View)

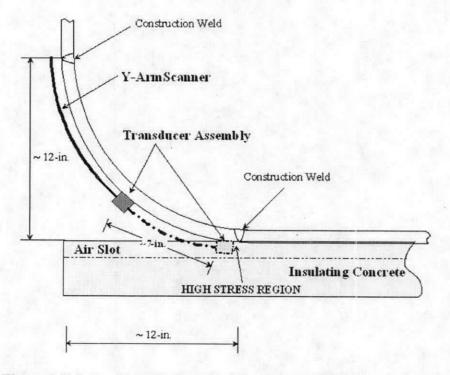


Figure 3.6. Lower Knuckle Examination in Air Slot Regions (Side View)

H-2-90538, Rev.1 H-2-90553, Rev.4

4.0 Ultrasonic Examination Location

Tank 241-AP-101 is located in the Hanford 200 East area in AP Tank Farm. The crawler and associated scanner were lowered into the 24-in. riser located on the west side of 241-AP-101 and designated as Riser 31. Riser 31 was originally called out as Riser 6 West. Figure 4.1 provides a graphic of the location of this riser.

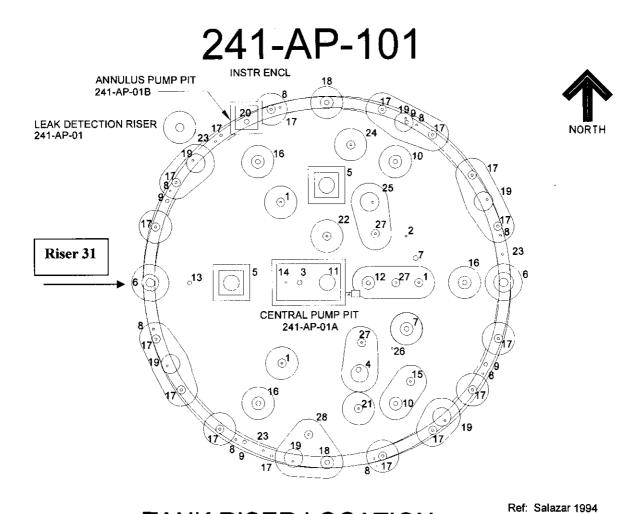


Figure 4.1. UT of 241-AP-101 from Riser 31

TANK RISER LOCATION

Figure 4.2 describes the areas on the primary wall of Tank 241-AP-101 that were ultrasonically examined. Two 15-in.-wide vertical scan paths were performed on Plates #1, #2, #3, #4, and #5 below the entrance to Riser 31. Vertical weld HAZ examinations were done on Plates #2, #3, #4, and #5, and the horizontal weld HAZ examination was done on the transition Plate #5 to knuckle weld. The upper portion of the knuckle was examined as well as four areas that extended down to the lower knuckle weld in the air slot regions.

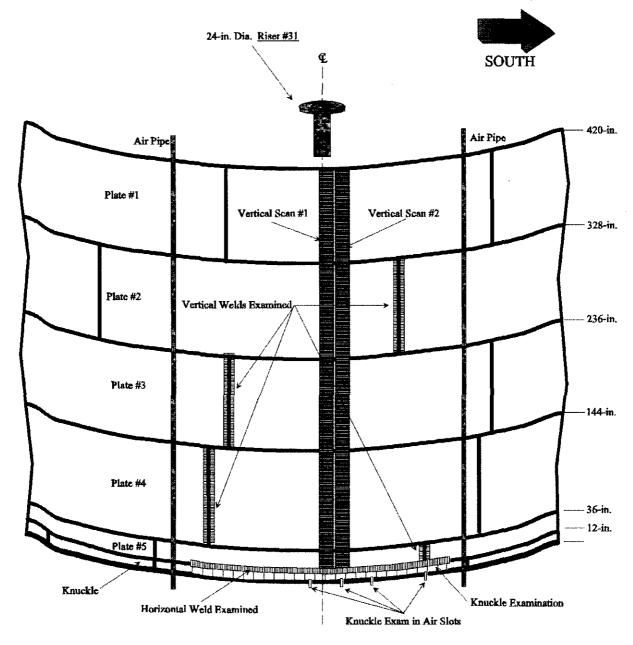


Figure 4.2. Sketch of Scan Paths on Tank 241-AP-101

5.0 Ultrasonic Examination Results

COGEMA has provided detailed reports including T-Scan and P-Scan hard copies of all areas that were ultrasonically examined to PNNL for third-party review. The data was analyzed by COGEMA Level III Mr. Wes Nelson and peer reviewed by JBNDT Level III Mr. Jim Elder. The results of the examination of Tank 241-AP-101 are presented in Figures 5.1, 5.2, and 5.3.

Figures 5.1 and 5.2 show the examination of the primary tank wall and the HAZs of both vertical and horizontal welds. The examination consisted of two vertical paths beneath the 24-in. diameter riser. Vertical scan #1 was 15-in. wide on Plates #1, #2, #3, #4, and #5 and was directly below the 24-in riser. Vertical scan #2 was adjacent to vertical scan #1 and was also 15-in. wide on Plates #1, #2, #3, #4, and #5. The HAZs of vertical welds in Plates #2, #3, #4, and #5 were examined and the HAZ in the horizontal weld between Plate #5 and the Knuckle section were also examined. Areas in the figures that show two measurements in the same box are the result of the vertical scan paths overlapping the horizontal HAZ scan paths or where the inspectors started a new scan and overlapped a previous scan. Figures 5.1 and 5.2 display the minimum reading taken in each 15-in. wide by 12-in. long portion of the scan. In the overlapping areas, both minimum readings from each of vertical and horizontal scan paths are given.

Figure 5.3 shows the examination performed on the knuckle of the primary tank wall. The readings distributed around the circumference of the tank knuckle represent the minimum reading in each 12-in. long by 12-in. wide portion extending down around the knuckle. The four areas denoted as Slot 1, Slot A, Slot B, and Slot D, represent small areas that were scanned extending down to the lower knuckle weld in the air slots. These scan areas are approximately 1-in. long (increment direction around the circumference of the tank), and 7-in wide (scan direction is down around the knuckle and into the air slot) as shown previously in Section 3 of this report.

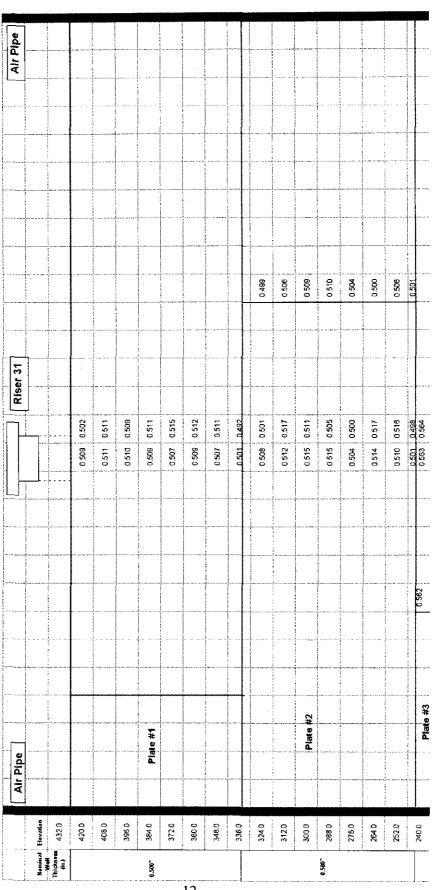


Figure 5.1. UT Data from Tank 241-AP-101

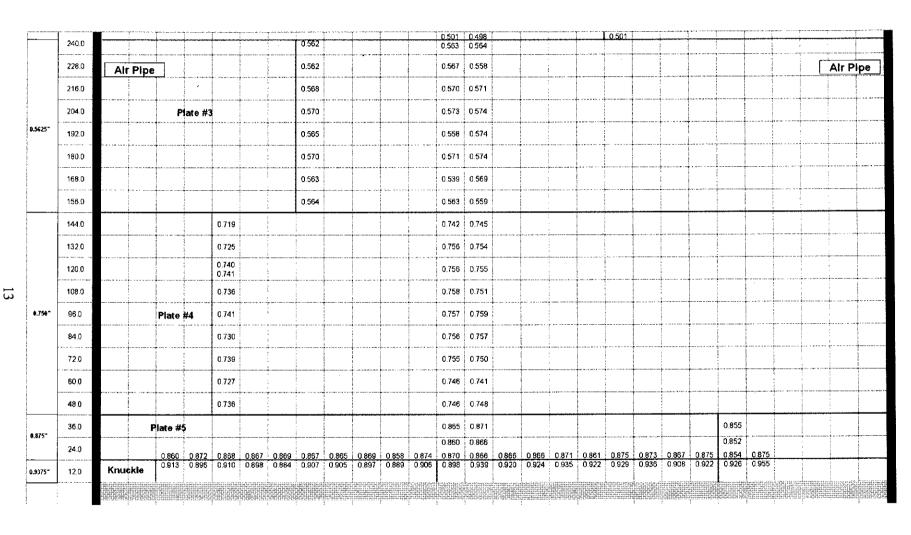


Figure 5.2. UT Data from Tank 241-AP-101 cont.

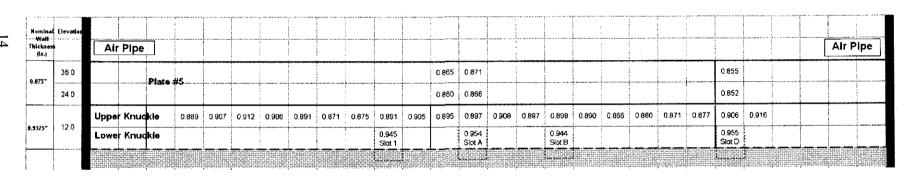


Figure 5.3. UT Data from Tank 241-AP-101 cont.

6.0 Conclusions

The results of the examination of Tank 241-AP-101 have been evaluated by PNNL personnel. The examination consisted of two 15-in. wide scans over the entire height of the tank, the HAZs of 4 vertical welds and 1 horizontal weld, and examination of the knuckle region. The examination was performed to detect any wall thinning, pitting, or cracking in the primary tank wall.

6.1 Primary Tank Wall Vertical Scan Paths

Two 15-in.-wide scan paths were performed on Plates #1, #2, #3, #4, and #5. The plates were examined for wall thinning, pitting, and cracks oriented vertically on the primary tank wall. The results indicated that the minimum thicknesses in the areas scanned with nominal thickness of 0.500-in. were as follows; Plate #1 was 0.492-in. and Plate #2 was 0.498-in. The nominal thickness in Plate #3 is 0.5625-in. and the minimum thickness in this area was 0.539-in. The nominal thickness in Plate #4 is 0.750-in. and the minimum thickness in this area was 0.741-in. The nominal thickness in Plate #5 is 0.875-in. and the minimum thickness in this area was 0.860-in. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or vertical crack-like indications were detected in Plate #1, #2, #3, #4, or #5.

6.2 Primary Tank Wall Weld Scan Paths

The HAZs of vertical welds in Plates #2, #3, #4, and #5 were examined for wall thinning, pitting and cracks oriented either perpendicular or parallel to the weld. The results indicated that the minimum thicknesses in the weld areas scanned were as follows: The nominal thickness of Plate #2 is 0.500-in. and the minimum thickness in this weld area was 0.499-in. The nominal thickness in Plate #3 is 0.5625-in. and the minimum thickness in this weld area was 0.562-in. The nominal thickness in Plate #4 is 0.750-in. and the minimum thickness in this weld area was 0.719-in. The nominal thickness in Plate #5 is 0.875-in. and the minimum thickness in this weld area was 0.852-in. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld areas in Plate #2, #3, #4, or #5.

The HAZ of the horizontal weld between Plate #5 and the tank knuckle was examined for wall thinning, pitting and cracks oriented either perpendicular or parallel to the weld. The results indicated that the minimum thickness in the weld area with nominal thickness of 0.875-in. on Plate #5 was 0.854-in. The minimum thickness in the weld area with nominal thickness of 0.9375-in. on the knuckle was 0.884-in. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or crack-like indications were detected in the weld areas on Plate #5 side or on the knuckle side of the horizontal weld.

6.3 Primary Tank Wall Knuckle Scan Paths

The upper portion of the knuckle area was scanned utilizing the Y-arm scanner attached to the AWS-5D crawler. The Y-arm scanned the transducers down around the knuckle approximately 12-in. from a starting position 2-in. down from the upper knuckle weld joining Plate #5 to the knuckle. The knuckle was examined for wall thinning, pitting, and cracks oriented circumferentially around the primary tank. The results indicated that the minimum thickness in the approximately 20 circumferential feet of knuckle area examined with nominal thickness of 0.9375-in. was 0.880-in. There were no areas that exceeded the reportable level of 10% of the nominal thickness. No pitting or circumferentially oriented crack-like indications were detected in the upper portion of the knuckle area.

Four small areas on the lower portion of the knuckle area were examined for wall thinning only utilizing the Y-arm scanner in areas accessible through selected air slots. The four areas examined were in air slots designated as Slot1, Slot A, Slot B, and Slot D. The results indicated that the minimum thickness in the lower portion of the knuckle area, with nominal thickness of 0.9375-in., in the selected air slots was 0.944-in. There were no areas that exceeded the reportable level of 10% of the nominal thickness.

7.0 References

Jensen, C. E., 2002, Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks FY2003, RPP-11832, Rev 0, September 2002, CH2M Hill Hanford Group, Inc., Richland, Washington.

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A. F. Pardini (6)	K5-26
G. J. Posakony (1)	K5-26

ATTACHMENT 6

RONDE ULTRASONIC EXAMINATION OF DOUBLE-SHELL TANK 241-AP-101 KNUCKLE REGION EXAMINATION COMPLETED <u>APRIL 2003</u> (PNNL THIRD PARTY REVIEW) This page intentionally left blank.

RONDE Ultrasonic Examination of Double-Shell Tank 241-AP-101 Knuckle Region Examination Completed <u>April 2003</u>

AF Pardini GJ Posakony

May 2003

Prepared for the U.S. Department of Energy under Contract DE-AC06-76RL01830

Pacific Northwest National Laboratory Richland, Washington 99352 This page intentionally left blank.

Summary

COGEMA Engineering Corporation (COGEMA), under a contract from CH2M Hill Hanford Group (CH2M Hill), has performed an ultrasonic examination of the knuckle region of Double-Shell Tank 241-AP-101 utilizing the Remotely Operated Nondestructive Examination (RONDE) system (also known as the SAFT/TSAFT system) (Pardini et al. 2001). The purpose of this examination was to provide information that could be used to evaluate the integrity of the knuckle region of the primary tank. The requirements for the ultrasonic examination of Tank 241-AP-101 were to detect, characterize (identify, size, and locate), and record measurements made of any circumferentially oriented cracks that might be present in the knuckle area of the primary tank. Any measurements that exceed the requirements set forth in the Engineering Task Plan (ETP), RPP-11832 (Jensen 2002), are reported to CH2M Hill and the Pacific Northwest National Laboratory (PNNL) for further evaluation. Under the contract with CH2M Hill, all data is to be recorded on disk and paper copies of all measurements are provided to PNNL for third-party evaluation. PNNL is responsible for preparing a report(s) that describes the results of the COGEMA ultrasonic examinations.

Examination Results

The results of the ultrasonic examination of the knuckle region of Tank 241-AP-101 provided by COGEMA have been evaluated by PNNL personnel. The results of the examination of Tank 241-AP-101 indicated no circumferential crack-like indications were present anywhere in the knuckle region between the upper knuckle weld and the lower knuckle weld over the approximately 240 circumferential inches scanned.

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1.0 Introduction

COGEMA Engineering Corporation (COGEMA), under a contract from CH2M Hill Hanford Group (CH2M Hill), has performed an ultrasonic examination (UT) of selected portions of Double-Shell Tank (DST) 241-AP-101 utilizing the Remotely Operated Nondestructive Examination (RONDE) system (also known as the SAFT/TSAFT system) (Pardini et al. 2001). The purpose of this examination was to provide information that could be used to evaluate the integrity of the knuckle region of the DST. The requirements for the UT of Tank 241-AP-101 were to detect, characterize (identify, size, and locate), and record measurements made of any circumferentially oriented cracks that might be present in the knuckle area of the primary tank. Any measurements that exceed the requirements set forth in the Engineering Task Plan (ETP), RPP-11832 (Jensen 2002), are reported to CH2M Hill and the Pacific Northwest National Laboratory (PNNL) for further evaluation. Specific measurements that are reported include the following:

• Circumferentially oriented stress-corrosion cracks that exceed 0.10 in. (through-wall) that are detected in the inner wall of the tank knuckle.

The accuracy requirements for ultrasonic measurements are as follows:

- Cracks size the depth of cracks on the inner wall surfaces within ± 0.1 in.
- Location locate all reportable indications within ±1.0 in.

Under the contract with CH2M Hill, all data is to be recorded on disk and paper copies of all measurements are provided to PNNL for third-party evaluation. PNNL is responsible for preparing a report(s) that describes the results of the COGEMA UT.

2.0 Qualified Personnel, Equipment, and Procedures

Under contract from CH2M Hill, qualification of personnel participating in the DST inspection program, the UT equipment (instrument and mechanical scanning fixture), and the UT procedure that will be used in the examination of the current DST is required. Personnel participating in the examinations are to be certified in accordance with American Society for Nondestructive Testing (ASNT) Guideline SNT-TC-1A-92 and associated documentation is to be provided. The capability of the UT system, including personnel and procedures, is to be validated through a Performance Demonstration Test (PDT) on a mock-up simulating the actual DST. The current procedure for the UT is to be based on the Section V, Article 4, *Boiler and Pressure Vessel Code* defined by the American Society for Mechanical Engineers (ASME).

2.1 Personnel Qualifications

The following individual was qualified and certified to perform UT of the Hanford DST 241-AP-101 knuckle region utilizing the RONDE system:

• Mr. Wesley Nelson, ASNT Level III in UT (#LM-1874), has been identified as COGEMA's UT Level III authority for this project. Mr. Nelson has been certified by COGEMA as a UT Level III in accordance with COGEMA procedure COGEMA-SVCP-PRC-014, latest revision. Further documentation has been provided to establish his qualifications. (1)

2.2 Ultrasonic Examination Equipment

CH2M Hill and PNNL have provided the UT equipment for the examination of the knuckle region of Tank 241-AP-101. This equipment consists of a Force Institute AWS-5D remote-controlled, magnetic-wheel crawler for transporting the PNNL RONDE scanning bridge. Ultrasonic transducers used for the examinations are commercial off the shelf. The RONDE ultrasonic system has been qualified through a PDT administered by PNNL.⁽²⁾

2.3 Ultrasonic Examination Procedure

COGEMA has provided the RONDE UT procedure for the examination of Tank 241-AP-101. This procedure, COGEMA-SVUT-INS-007.5, Revision 0, outlines the type of UT and mechanical equipment that are to be used as well as the types of transducers. Only angle-beam transducers are used for the examination of the knuckle region of the primary tank wall. The examination procedures include full documentation on methods for calibration, examination, and reporting. Hard copies of the SAFT/TSAFT views of all areas scanned are made available for analysis. The UT procedure requires the use of specific UT transducers for the knuckle examinations. A calibration performed before and after the examinations identifies the specific transducers used and the sensitivity adjustments needed to perform the inspection. The COGEMA UT procedure has been qualified through a PDT administered by PNNL. (a)

3.0 Ultrasonic Examination Configuration

COGEMA is required to inspect selected portions of the DSTs that may include the primary and secondary tank walls, the heat-affected zones of primary tank vertical and horizontal welds, and the tank knuckle and bottoms. The RONDE system has been configured to perform the examination of the knuckle region. The RONDE examination of Tank 241-AP-101 concentrated on the knuckle region from

⁽¹⁾ Reference: "SAFT/T-SAFT Performance Demonstration Test (PDT) (Mr. Wesley Nelson)," dated November 14, 2002.

⁽²⁾ E-mail from Gerald J. Posakony to Susan L. Crawford and Allan F. Pardini, dated September 27, 2002, "SAFT-T-SAFT PDT."

the upper knuckle weld to the lower knuckle weld (approximately 19 in. measured on the inside diameter) and extended circumferentially around the tank approximately 240 in. Figure 3.1 provides an image of the actual equipment and configuration for the examination of the knuckle region of the primary tank and the approximate location of the scanner during normal operation.

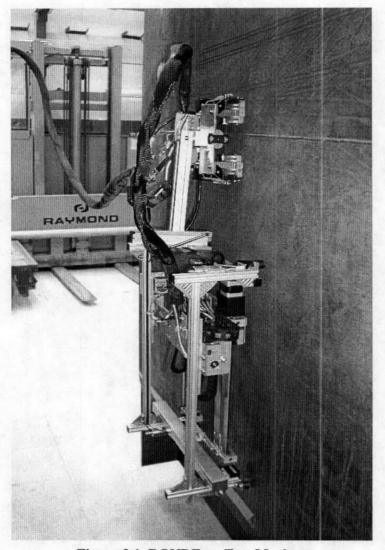
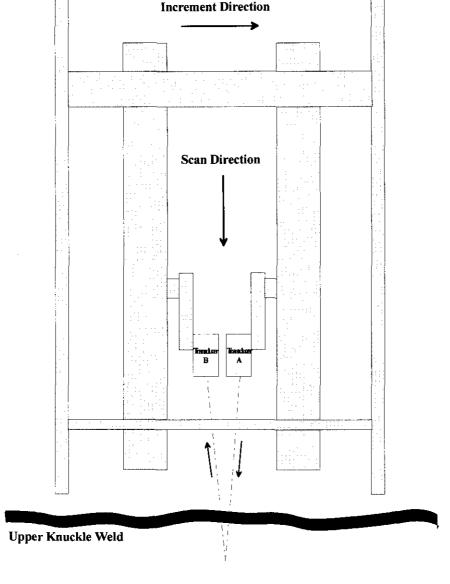


Figure 3.1 RONDE on Test Mockup

The functional diagram in Figure 3.2 shows two 70° angle-beam transducers in a pitch-catch arrangement for examining the knuckle region of the primary tank. The angle beam transducers are designed to detect and record any circumferential cracking that may be present. These transducers are attached to the scanning bridge and can move together or individually. During crack detection scanning, the two transducers move together in unison, transducer A "pitching the sound" and transducer B "catching the sound." If a crack is detected, the two transducers are operated individually in a passing motion allowing for sizing of the detected crack. During detection scanning, information is captured

every 0.025 in. (or as set by the NDE inspector) as the transducers are scanned down towards the knuckle. At the end of each scan line, the fixture is incremented 0.25 in. (or as set by the NDE inspector) and the next scan line is acquired. The mechanical scanning fixture is designed to scan the transducers approximately 10 in. by 12.5 in.; however, the sound field from the 70° transducer interrogates the entire volume of the knuckle and the C-scan (plan view) display of the data shows the entire knuckle, from the upper knuckle weld to the lower knuckle weld, and 12.5 in. in circumference. This C-scan display is immediately evaluated to identify any crack-like indications which may require additional scanning for sizing. If no crack-like indication is identified in the 12.5-in. circumferential area scan of the knuckle, the crawler transports the bridge to the next area. The hard copy C-scan view provides a permanent record that can be used for any subsequent analysis.



Transducer Specifications:

Type: MSW-QC Benchmark

Frequency: 3.5 MHz Size: 0.5" Diameter

Angle: 70 degree, Wedge W-213 Manufacture: Krautkramer

Figure 3.2 General Knuckle Scanning Arrangement

H-2-90538, Rev.1 H-2-90553, Rev.4

Ultrasonic Examination Location 4.0

Tank 241-AP-101 is located in the Hanford 200 East area in AP Tank Farm. The crawler and associated RONDE scanner were lowered into the 24-in, riser located on the west side of 241-AP-101 and designated as Riser 31. Riser 31 was originally called out as Riser 6 West. Figure 4.1 provides a graphic of the location of this riser. Figure 4.2 describes the area on the primary tank wall knuckle of Tank 241-AP-101 that was ultrasonically examined.

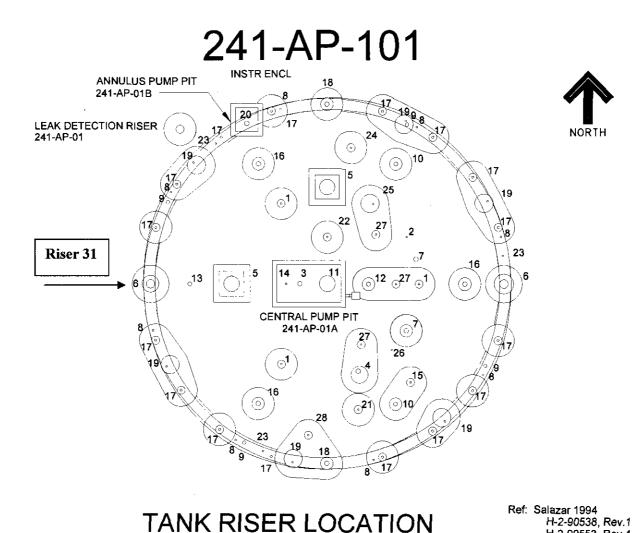


Figure 4.1 UT of Tank 241-AP-101 from Riser 31

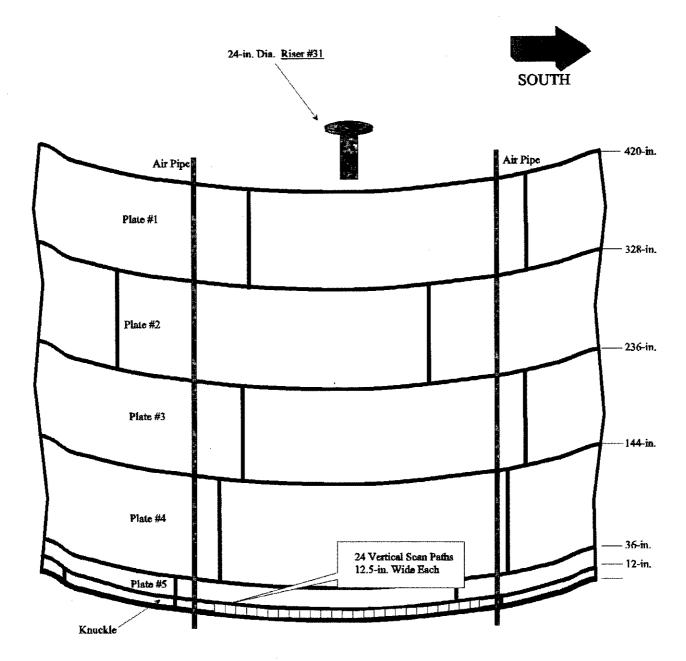


Figure 4.2 Sketch of Scan Paths on Tank 241-AP-101

5.0 Ultrasonic Examination Results

COGEMA has provided detailed reports and data of all areas of the knuckle region on Tank 241-AP-101 that were ultrasonically examined to PNNL for third-party review. The data was analyzed by COGEMA Level III Mr. Wes Nelson. Upon receipt of the data, PNNL staff members Susan Crawford, Jerry Posakony, and Al Pardini performed a peer review of the results.

The examination consisted of 24 individual scans, each being 12.5 in. in width (circumferential direction). The crawler was moved around the circumference in 10-in. increments, thereby providing for a 2.5-in overlap during data acquisition. The total amount of knuckle scanned was approximately 240 in. measured circumferentially around the tank. The data was displayed in a C-scan (plan) view and provided an image of the entire knuckle, from upper knuckle weld to lower knuckle weld (approximately 19 in. measured on the inside diameter), inclusive of the predicted high-stress region. Further analysis was performed on selected data files by PNNL using the SAFT analysis algorithm to verify position of the lower knuckle weld.

The results of the examination of Tank 241-AP-101 indicated no circumferential cracking was present anywhere in the knuckle region between the upper knuckle weld and the lower knuckle weld over the approximately 240 circumferential inches scanned.

6.0 Conclusions

The results of the examination of the knuckle region of Tank 241-AP-101 have been evaluated by PNNL personnel. The UT concentrated on the examination of the knuckle region from the upper knuckle weld to the lower knuckle weld (approximately 19 in. measured on the inside diameter) and extended circumferentially around the tank approximately 240 in. The data provided by the COGEMA Level III UT of the results of the examination of Tank 241-AP-101 indicated no circumferential crack-like indications were present in the approximately 240 circumferential inches scanned of the knuckle region.

7.0 References

Jensen, C. E., 2002, Engineering Task Plan for the Ultrasonic Inspection of Hanford Double-Shell Tanks FY2003, RPP-11832, Rev 0, September 2002, CH2M Hill Hanford Group, Inc., Richland, Washington.

Pardini, A. F., et al. 2001. Annual Report – Development of a Remotely Operated NDE System for Inspection of Hanford's Double Shell Waste Tank Knuckle Regions, PNNL-13682, Pacific Northwest National Laboratory, Richland, Washington.

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